

WOODNEWS

Furniture and Manufacturing Technologies JULY - AUG | 2014 | Bi-monthly | Vol. 24 · No. 2 | ₹100



Special Focus

DOORS

Homag's primer on setting up a production factory

INTERVIEW



Kleiberit:
Inventor Klaus Becker-Weimann on HotCoating technology



Coast to Coast:
CEO Heinz Moritzhuber on shift to veneer door manufacturing

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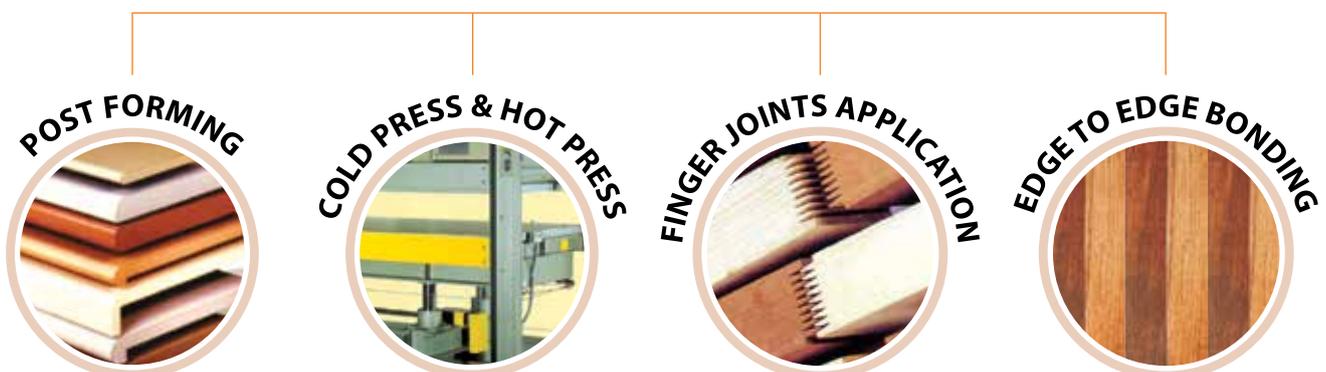
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M/S WOODTECH CONSULTANTS PVT LTD.
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Founding Publisher | **Gouri Ramakrishnan**

Founding Editor | **Dr. Joseph George**

Chief Editor | **Dhananjay Sardeshpande**
dhananjay@pdatrademedia.com

Contributing Editors

Dr. Ernst Kürsten | daad.fri@t-online.de

D. S. Murali Krishna | muralikrishna@squareball.net

Prof. K. Jaisim | jaisim@gmail.com

Industry Consultants

V. Ramakrishnan | Director, Leitz Tooling Systems India Pvt. Ltd.

Winston Chiu | President, Technik Associates, Inc.

Copy Editor | **Suraj Uprety**

suraj@pdatrademedia.com

VP - Publications | **Binesh Viswanath**

binesh@pdatrademedia.com

General Manager - Design | **Infant Vikas**

vikas@pdatrademedia.com

Advertisement Manager | **Zindal Kumar**

zindal@pdatrademedia.com

Corporate Sales Executives | **Apratim Sarkar**

apratim@pdatrademedia.com

Manager - Design | **Ramesha K S**

ramesha@pdatradefairs.com

Design | **Wageeshwari Tuljapurkar**

wageeshwari@pdatrademedia.com

Govindaraju S | govind@pdatradefairs.com

Circulation Executive | **Karthik K**

karthik@pdatrademedia.com

Taiwan, China and Hong Kong:

Robert Yu,

Worldwide Services Co., Ltd., 11F-B, No. 540,
Wen Hsin Road, Sect. 1, Taichung, 408, Taiwan.

Tel.: +886-4-2325-1784 Fax: +886-4-2325-2967

Email: erin@acw.com.tw

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Tel.: +91-80-4250-5050 Fax: +91-80-2551-3078

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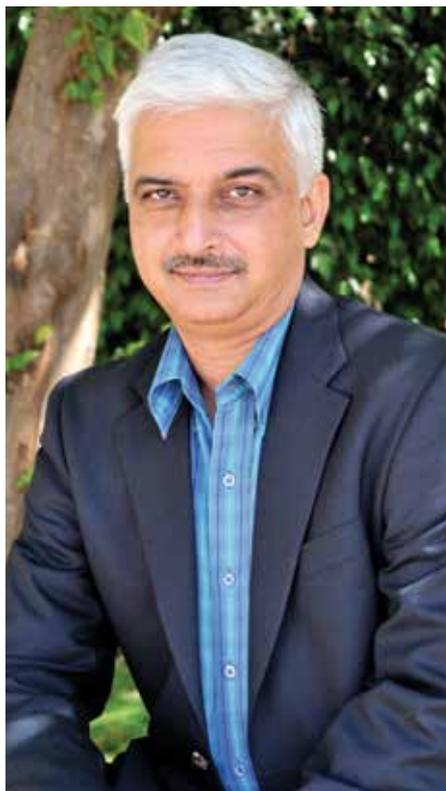
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EDITORIAL



Hello Readers!

General elections came, we all saw wisdom in change, and voted a new government in place. Without peering over our shoulders at the recent years of economic 'stagflation', Indian industry and businesses must now look forward to, and work for, progress on various fronts. Besides a no-nonsense attitude, the new Union ministry seems to have given out an unequivocal signal to all sections of society: 'We (govt.) will help all those who help themselves'! This is a sure call to get going in all our ventures, businesses and further building up on the progress we have made since liberalisation more than 20 years ago.

The expansion of the real estate business – more than half of India's 1.20 billion population still needs modern housing – is one cause for great optimism. When I realised the huge potential on this front one sector, that of door manufacturing, comes to mind naturally. The wide range of machines, processes, technologies, consumables, fittings – and dependable consultants – that are readily available in the Indian market today make door manufacturing an even more attractive business proposition!

Many of you have already sown seeds and are reaping its benefits; yet others are eyeing the business and are putting in place plans for the future. I hope that for the latter section of this magazine's readers, the articles on door manufacturing in this issue will help in some way or the other.

There is more good news in this issue: after years of internecine rivalry the Italian woodworking industry – already in the throes of concern on dipping supplies and orders from the global markets – seems to have got its act together. After riding out recent storms, Acimall (the association of Italian woodworking machinery manufacturers) successfully organised Xylexpo 2014. On the other hand, FMC China (in September 2014) seems to have its heart set on the right direction: making 'smart' homes!

In its ongoing efforts to educate its markets (consumers and influencers alike) about engineered wood, Associate Decor has published a book, which was appropriately released at the India Kitchen Congress in Bangalore in May. Commendable indeed. There is more in this issue than I can enumerate here, but leave it to you to choose what interests you. Before I sign off, a reminder: do send in your comments, suggestions and ideas on the magazine to editor@woodnews.in. Happy reading!

Dhananjay Sardeshpande



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Doors to bigger business opportunities

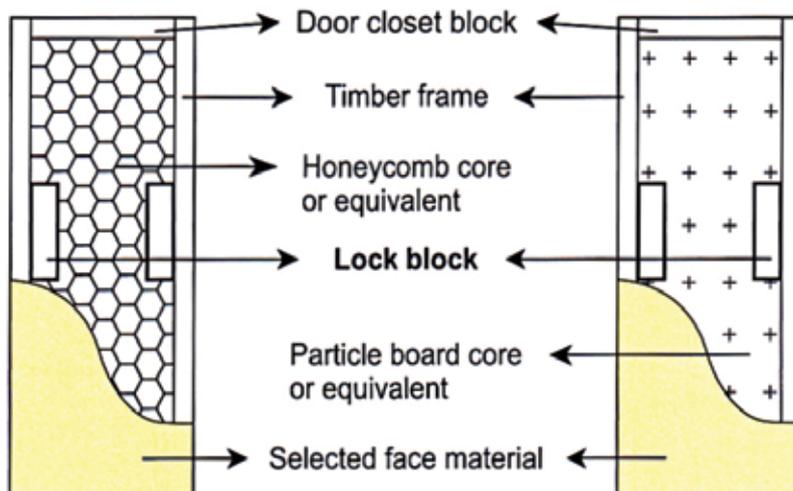
Homag-India illustrates a typical set-up of a production factory

The readymade door market in India is huge and ready to be tapped. Readymade doors and doorframes is a lucrative investment opportunity in India - it is an attractive project that offers high value addition and returns.

The current Indian market size for doors and door frames is estimated to be around Rs. 6,000 crore, with timber-based doors accounting for almost 75% of the market share.

With not many organized players in this segment, and urbanisation continuing at a very fast pace, it is the most appropriate time to cash in on the opportunity available to entrepreneurs in the woodworking industry.

Types of Door Construction





 Typical solid-wood panel doors.

Solid panel doors

Solid wood panel doors can be made with single or multiple panel, stiles & the use of glass and decorative fittings. It can be of the single leaf (opening

left to right, or vice versa), two leaf or folding types.

Depending on requirements, one can also make and install sliding doors (to free up more space), rotating doors (for areas where many people constantly enter and exit an

architectural space) & screen doors (to let in air, but keep out insects).

Louvre doors are an attractive way to provide privacy and security while allowing for the free flow of air on both sides of the louvers. Louvered bi-fold doors are most commonly used for closets or as a screen for a dressing area.

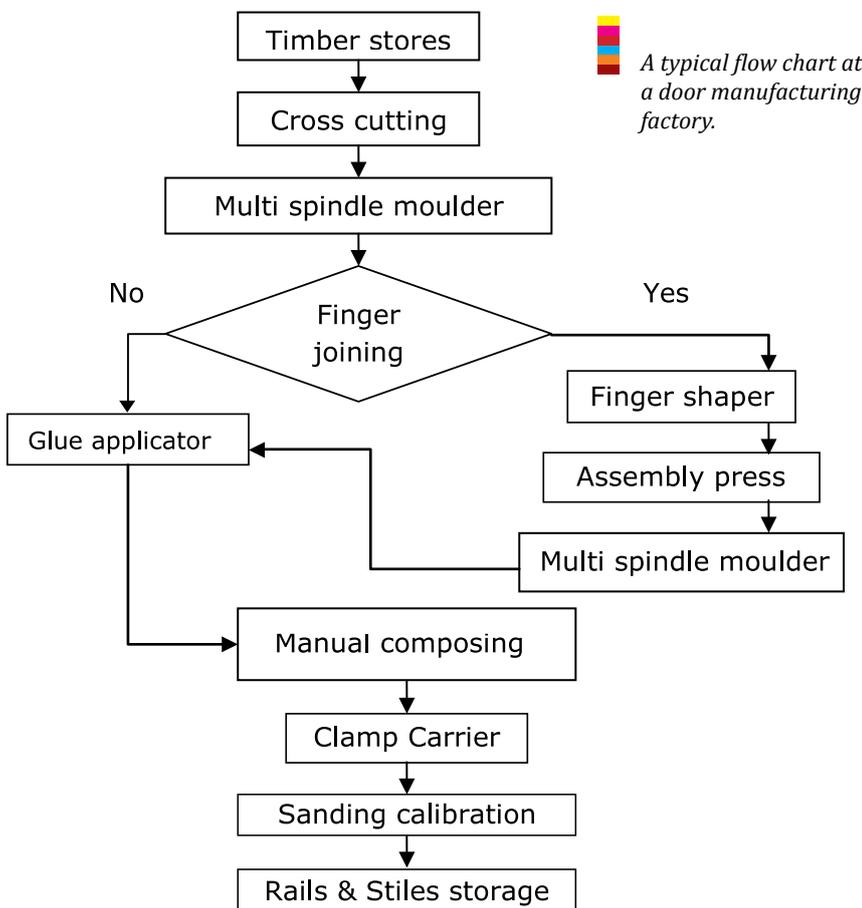
Flush doors

Flush doors, on the other hand, are simple interior and exterior doors with plain faces on both sides of their construction. These doors are associated with functionality, rather than style, and may be made from solid or hollow cores.

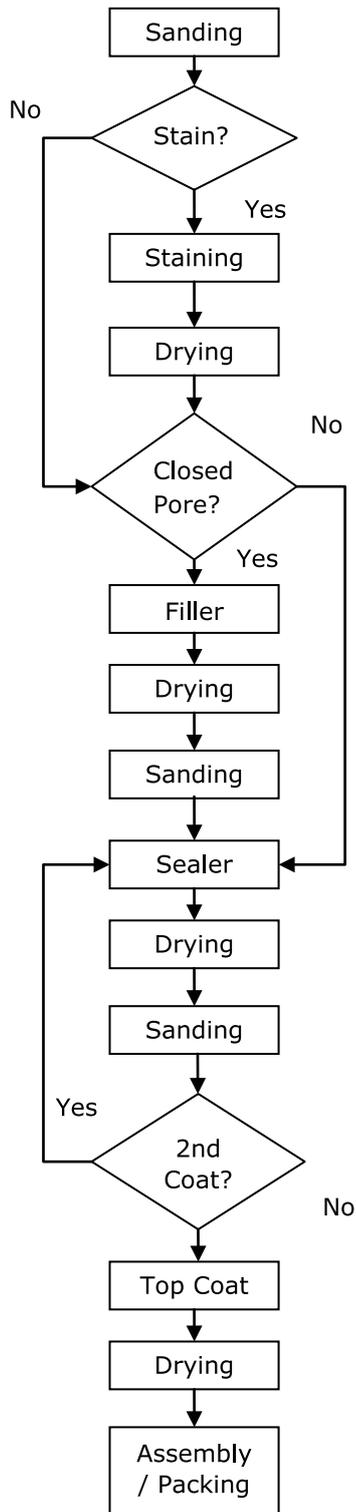
A typical flush door is manufactured with two sections of plywood attached to each side of a frame. The interior of the door has some form of support built into the frame, commonly a honeycomb support system.

A flush door can also be manufactured using a solid core piece that is augmented with some laminate or plywood on each side. As with the hollow core design, the solid model is painted, then treated to a sealant. The plywood can be finished to accentuate the wood grain, or covered with protective paint in interesting patterns; or dressed in attractive door skins.

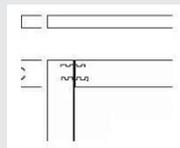
Among the machinery and equipment required in the production of doors 



 A typical flow chart at a door manufacturing factory.

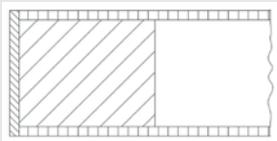


Flow chart of a typical finishing line for factory-made doors and door frames.



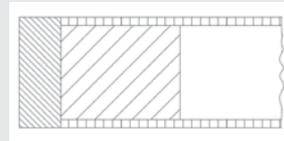
- The stile and rail of the flush door can be either finger jointed lengths of solid wood or MDF.
- The stile and rail will be joined by corrugated staples.

Solid wood stile with thin veneer edge band



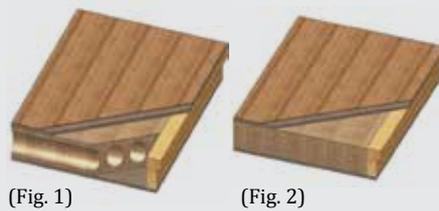
(Fig. 1)

MDF stile with wood lipping



(Fig. 2)

- When the stile and rail are solid wood, finger jointed the edge will have a thin veneer edge band. (Fig.1)
- When the stile and rail are MDF, the edge will have a solid wood lipping. (Fig.2)

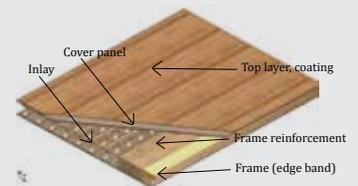


(Fig. 1)

(Fig. 2)

- low density particle board (Fig. 2) or hollow tubular particle board (Fig. 1) or paper honey comb.

- The overall construction of the flush door shutter will be as shown on the left.



- The door frame for both flush and solid panel door can be made of solid wood.
- The joinery of door frame can be miter with tenon.

- The stile and rail of the solid panel door will be connected with tenon and mortise as illustrated.



A diagrammatic representation of how doors are made.



There are multiple varieties of flush doors with different cores, construction and finishes, depending on their use and deployment.



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Inside bead on stile being machined. Note that the shape is upside-down from what you normally see.



Thermwood's CNC router, the CS45-QC.

Other than a simple slab, doors are basically variations of the traditional 5-piece door. MDF doors are single piece doors designed to look like 5-piece doors. A 5-piece door is made of two horizontal rails, two vertical stiles and a centre panel.

The centre raised panel, which is generally made of solid wood, floats in a frame made from the stiles and rails. It floats because solid wood expands and shrinks with changes in moisture; and if we attach the centre panel to the frame, the door will warp with changes in moisture.

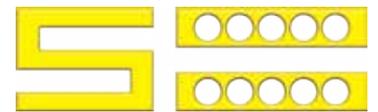
Also, if it shrinks enough, the finish splits where the raised panel enters the frame and a line appears that is not good for your bottom line. The larger the door, the greater is the effect.

Most of you know this already, but few realize that there is an alternative that



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The outside edge is first cut with a straight bit and then the outside profile is added.

works well, even for large doors. As a bonus it is less expensive!

The alternative approach is something Thermwood CNC Router developed when working on furniture designs. It reduces the use of solid wood to components that must have a shape or profile cut into them, and uses veneer-covered plywood for the other components.

Since the centre panel is almost always



Centre panel outline is first cut with a straight bit, then the rise is machined in several passes automatically.

plywood in this approach, and the amount of solid wood is minimized, the tendency to warp is all but eliminated. To understand this approach, let us look at couple of examples from Thermwood furniture network.

The first is a door from our Italian Renaissance Credenza. In finished form it appears to have up to 10 quarter stiles and rails and a flat centre panel. In solid walnut, this would be a very expensive piece if built in a traditional



Top rails being cut. Note the copes were cut first to reduce tear-out and the cathedral shape was cut with a straight bit before profiling.

manner.

This same design is used on the end panels, which are rather large and would be difficult to keep flat using solid wood.

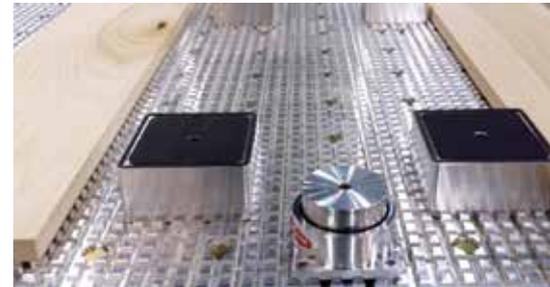
In our approach we start with a walnut veneer-covered plywood slab the size of the finished door. To this we glue stiles and rails, also made of veneered plywood. Then for the profiles centre shape, we used shaped walnut (in this case we modelled it instead of buying a profile tool). Finally, we edge-banded the outside of the door to obtain the final result.

As you can see, the final result is very attractive and both stable and reasonably economical. Now let us look at another example.

The Italian door we just discussed can probably be made using traditional tools, but the approach for the second door most likely needs a CNC router because some of the fit tolerances are too tight for manual machines.

A door from our Brittany Credenza line appears to be raised panel door with a modified arch top. Built in traditional manner, it has typical stiles and rails; but the relatively large raised panel can easily be a source for expansion and contraction problems.

It would be nice to make this centre panel from plywood but, since it has a profile rise cut around its outside, a new approach must be found. Our solution is to make the raise, which is normally part of the centre panel, part



of the stiles and rails instead.

Then, the flat part of the centre panel can be made from plywood and edge glued to the stiles and rails. The result looks almost identical to the traditional raised panel door, but without potential problems.

The only real difference in appearance is that there is a joint in the centre panel raise and would not be there if raise was cut into a solid wood centre panel. This can be virtually eliminated by the finishing process and is noticed by almost no one, not even experienced furniture builders.

It is important that joints between the stiles, rails and centre panel be tight and true. This is where a CNC router is vital. It can create a match joint that would be all but impossible any other way.

Thermwood's furniture programme continues to expand. You might even find some areas in your own products where this approach might be exactly what you need!

Thermwood Corporation is the oldest and most technically advanced manufacturer of CNC routers in the world, with hundreds of patents to its name. The US-based company also develops, manufactures, distributes and supports allied software, technology, equipment and services, ranging from woodworking and plastics to aerospace and entertainment.

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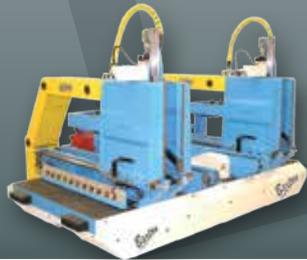
▽ *Band saws headrigs*

- SCB 1500



▽ *Log carriages with independent headblocks*

- CPTN 2A4 ECO
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△ *Complete line based on log carriage and band saws headrigs*

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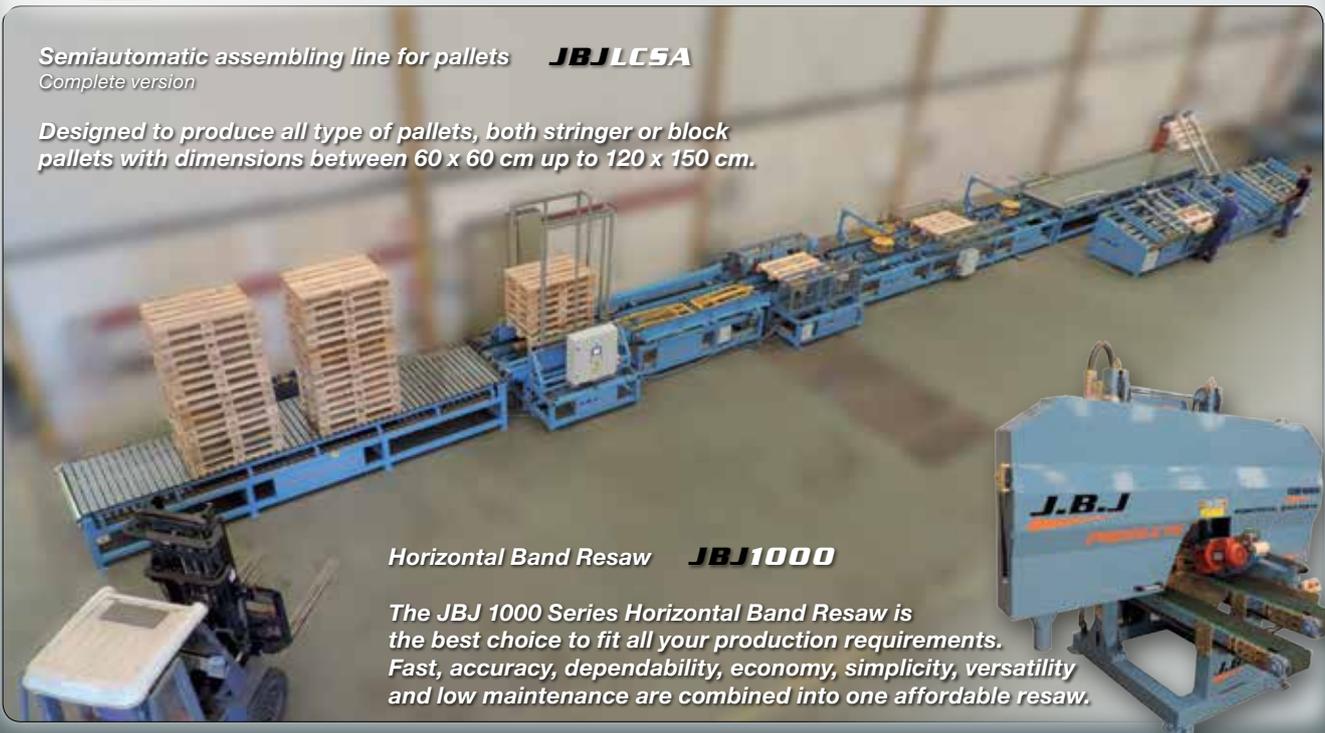
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MDF is perfect base for veneer doors

Coast to Coast Designs Pvt. Ltd. is among the biggest resellers of wood veneer in India, offering more than 130 varieties in different colours, cuts and figures. Building on its decades-old expertise and trust with its huge clientele, it has set up an ultra-modern factory near New Delhi to manufacture 2,500 doors and door frames per month. *WoodNews* caught up with Austrian woodworking expert, entrepreneur and the company's CEO, **Mr. Heinz Moritzhuber**, to find out more:



What are the advantages of veneer doors?

For decorative veneers, only the very top quality of wooden logs are selected and used. From one wooden log with a diameter of 1.5 feet and a length of 10 feet, up to 70 doors with decorative veneer (both sides) can be manufactured. With the same wooden log a maximum of four solid doors can be manufactured.

Veneer is also environment-friendly. Trees take 20 years and more to become usable for the wood industry. In veneered products the consumption of these beautiful trees is minimal compared to solid wood. That saves a lot of trees and makes it possible to balance the demand with the re-plantation of these beautiful slow growing trees.

Is veneer popular in India? Is it suitable for Indian climates?

Yes, veneers are very popular in India. If veneer is processed in the right way, with the appropriate splicing and pressing technology, on suitable base materials and with the right glue, veneers are very suitable for the extreme climate conditions we have in India.

For those who vouch for solid wood, how would you convince them to switch to MDF or ply board doors with veneer?

I would not like to convince anyone to switch to any of these materials. I would convince them to use from every one of these materials, including wood, the best properties and get an engineered product manufactured.

At Coast to Coast, for the outer core frame of a door we use solid wood, since solid wood has very good screw holding capacity on the top and on the side surface. Hinges need to be screwed and solid wood gives suitable strength for that. We use fast growing wood with a great screw holding capacity for long lasting performance of the door.



 CNC Router

The remaining area between the solid wood frames we construct with tubular filler boards. These boards are very balanced, preventing doors from movements like shrinkage, expansion, warping and bending. Compared to other materials these boards also have excellent acoustic properties. They are of a very high density: 1 square cm can take 20 kg of pressure. That is better than the best timbers in the world!

They are rated, as a standard configuration, 20-minute fire resistant. On both sides, on top of the wooden frame and the filler board, we glue our hot pressed MDF, depending on the location and the usage of the door, exterior or interior MDF.

MDF is one of the most balanced materials and provides the perfect base for larger veneered surfaces for perfect finishing of the decorative natural veneer surface. We use only imported high-quality water-proof glue from Germany and achieve a perfect bonding of the engineered door. The result is a balanced engineered door where the best properties of materials are used for the right function.

Why did Coast To Coast venture into door & door frame manufacture?

Coast To Coast's successful business model has always been aimed to meet the demand of the Indian market with specialised and excellent service. Coast To Coast started with importing decorative veneers for the industry and became one of the largest importers. The second phase saw splicing and pressing veneers as per customers' requirements.

As you surely know, the Indian market continues to be driven by using veneer pressed on 4-mm ply available with



 Paint-Booth



distributing channels in the market. Coast To Coast, therefore, started successfully offering its wide range of veneers pressed on base materials and group-matched as per the industry's requirement.

For example a wardrobe manufacturer wants to have a 24-mm-thick veneered wardrobe shutters with an 18-mm ply core and 3-mm balanced MDF on both sides for perfect finish. He wants to match all the wardrobe shutters with a panelling in the project that needs to be on 18-mm MDF. So Coast To Coast will select group-matched veneers, splice and press them for the manufacturer, direct on the wanted base material.

The manufacturer gets everything group-matched on the final base material ready for sizing and processing. Such applications are difficult to achieve with the 4-mm veneered ply from the market. We at Coast To Coast believe there is a reasonably big demand of customer-oriented door systems and we commit ourselves to specialise and to be of best service to this demand too.

How and where has your new factory come up? What is its production capacity?

Our factory is in Haryana, 15 km outside Delhi, on the Chandigarh highway. We are targeting to manufacture 2,500 doors per month.

What type of machinery and manufacturing technology has gone into the new factory?

Most (80%) of our machines are from leading manufactures in Germany and Italy. Another 20% are from leading manufacturers in India and Taiwan. The machines installed at our factory are: two veneer splicers, a veneer guillotine, two glue spreaders, two hot presses (one with 3 levels and another with 5 levels), wide-belt sanders, panel saws, seven spindle 4-side planer/moulder, two edge banding machines, a high speed CNC router with two aggregates, a modern paint booth with positive pressure, moulding and multi-boring machines.



What variety of doors are you making?

We offer 150 different veneer species in a wide range of engineered door designs. Besides our range of designs, we are working with leading architects and provide the best possible solutions to their creative designs.

Where do you source your raw material?

We import the best quality raw materials like wood, furniture quality (24-hour water resistant) ply, veneers, tubular filler-boards, glue, all by ourselves. We keep large stock levels of these imported raw materials. MDF and hardware we mainly source from importers.

How are the doors selling? Do you have your own shop(s), or dealers?

We have an experience centre (showroom) on MG Road in Gurgaon and a qualified sales team for the National Capital Region (NCR) of Delhi. For other states we are working with partners based on our operating model in NCR.

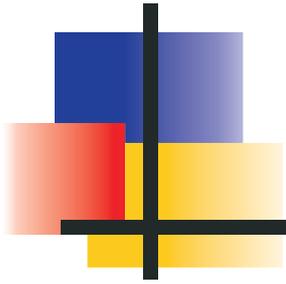
What about the doors frames? Do you make pre-hung doors?

We manufacture three types of door frames: solid door frames and frames manufactured out of imported ply as base material. These two systems are directly fixed on to the walls, and we also have an advanced system with sub-frames.

We fix these sub-frames in the very initial construction stage: at the time before the plastering of the walls starts. These sub-frames are fixed and plastered onto the wall and become a part of the wall. This guarantees perfect opening sizes and finishing levels, as per the customer's requirement and within our standardisation.

These sub-frames also provide and guaranty optimal, fast and easy fixing of the actual decorative inner door frames. In the ply frames the hinges are screwed only into the top surface, where the screw holding capacity is





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♦ Low Maintenance ♦ Easy to install





Panel-Saw

excellent. All hinges, locks and fittings like inserted door closers are all pre-routed in and pre-fixed in the factory.

Where does Coast To Coast stand in the Indian market? How is your product different?

My partners in Coast To Coast are excellent in what they do. They have wide experience and knowledge in selecting, buying and importing the best raw materials for doors from all over the world. I bring 30 years of experience in plant layout planning, machine selection and processing and manufacturing of solid wood and veneered products in Europe and India.

Our door system is designed, engineered and manufactured for fast and easy installation at sites. We provide solutions to install our doors and frames at a stage where the painting and flooring jobs are already done. A team of three installers takes less than 20 minutes to install a completed finished door frame with door and with all hardware.

All our door parts are exchangeable. In the event that something breaks after years of installing the doors, we can replace the part with very little effort and without damaging the walls or other parts of the door system.

Do your doors come with the

specifications of modern doors: acoustic properties, thermal & moisture resistance, protection from insects, etc.?

Yes, they definitely do. Our regular specification has very good acoustic properties; and we offer higher acoustic properties, if required. We use eco-friendly, water-based PU and acrylic finishes in open pore matte, semi-gloss and high-gloss. Additionally, we offer wax finishes as well. All finishing material is imported from Germany.

How is the business environment in India: its regulations, the market, the manufacturing infrastructure, business sentiment, etc.?

Honestly speaking, after being active for so many years in India, it is still sometimes difficult to understand the many regulations. Some of them are not productive for industry and business. On the other hand for such a large country in its unstoppable movement to growth, it's not easy to change these hurdles overnight. Overall I have seen a lot of growth in my long association with India.

What is your opinion of the woodworking industry in India?

I think it's a very creative, fast-growing and developing industry with a lot of scope for those who offer quality and service made for Indian conditions and requirements.



Veneer-Splicer



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Bürkle's Robust: backbone for door production



 Bürkle's Robust door manufacturing line.

Every door manufacturer knows the situation: customers request more and more rapid deliveries of individual doors, special door designs and particular dimensions in connection with "large-scale orders".

In the past such kind of enquiries were often refused, since handling of these enquiries was not economically feasible with the provided means. Today, the manufacture of quite a few special doors is the key for a good utilization of the existing lines for standard door production.

Door designs that lend themselves to door production lines are: 3 layer (skin, frame+core, skin), 5 layer

(veneer, flat board, frame+core, flat board, skin), 7 layer (as above, with additional flat inlays), 9 layer (as above, with additional flat inlays), 3 layer (moulded skins, frame, moulded skin), or a combination of any of the above.

Among new materials being used for door construction are prefabricated moulded doorskins, structure high-pressure laminated (HPL) surfaces and pre-painted surfaces.

Among materials used for cores and barrier laminates are metal sheets (aluminium, lead & steel), concrete-based fibre, second-grade lumber stiles and synthetic compound materials, such as polystyrene.

It is clear in everyone's mind: both wishes can normally not be actualized on a single line with the respective material management and partly considerable set-up times.

The traditional company and market leader, Robert Bürkle GmbH, has delivered press and finishing lines for the woodworking industry for more than 90 years. Its experiences and close cooperation with customers have resulted in timely technical solutions over decades.

One solution is Bürkle's manufacturing lines that can produce an extreme wide range of the possible door designs with batch size 'one' and capacities of up to 2,000 doors per shift, nearly without any set-up times. However, these lines require corresponding material handling and computerized order management for being able to work economically.

Three Options

Another and clearly more flexible solution is the new door production lines of Bürkle's Robust series. These lines combine well-proven line technology with the latest technical details, can be utilized independently and can be extended by various components of the extensive Bürkle range at any time.

The Robust series generally consists of a roller coating machine for glue application, RCG with four rollers for watery glues, a station for making available the materials and for manual joining of glued and non-glued door



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components like skins, inlays, frames and stiles, as well as of a heated through-feed press line with out-feed for removal of door blanks.

Three line types with different performance classes for the manufacture of door blanks of dimensions of up to 1,300mm x 2,400mm x 100mm are offered for being able to meet the capacity requirements of any door manufacturer:

Manufacturing line Robust 10 has a single-opening through-feed press for capacities of up to 150 doors per shift; line type Robust 20 comes with the classic Optima through-feed press with 2x1 openings for capacities of up to 280 doors per shift.

The largest line type, Robust 40, comes with Optima through-feed press with 2x2 openings for capacities of up to 550 doors per shift. Bürkle's door press lines of the Robust series are operated on a surface from approximately 60 square metres, by a maximum of three operators.

	Robust 10	Robust 20	Robust 40
Max. number of door blanks/shift:	150	280	550
Max. number of doors 're-veneering'/ shift:	515	870	1.600
Press openings:	1	2	4
Electrical connection kW:	22	31	38
Surface in m ² approx.:	60	60	75

An overview of Bürkle's door production capacities

Glue Application

For a proper glueing result and final function, the correct glue specification has to be chosen. In addition the glue has to be handled according to the application instructions. A proper glue line function depends on the correct mixture of components, adjustment

of the amount of application and application temperature.

For manufacturing purposes, two kinds of glue could be assorted: water-based glues (PVA, UF, EPI) and hotmelt glue (PU, PUR, EVA). For water-based glues, application with rollers with smooth or grooved surfaces is a must. Special application rollers are required for moulded panels.

Optional cooling of doctor rollers with coolant is required to ensure constant glue line temperatures, and a glue kitchen for automatic mixing of components.

For hotmelts (temperatures up to 160°C), application roller and doctor roller are heated by a separate shared heating unit operated with thermal oil.

Advantage UV-LED

- Uniform radiation of lamps across entire working width
- Reduced exposure to noise of line operators: no exhaust system required
- Step-less adjustment of the specific lamp power (20% to 100%)
- Instant on/off
- No waste disposal of UV lamps containing heavy metal (GA, Hg)
- No exposure of operators to ozone
- Excellent penetration of UV radiation with pigmented lacquers
- Less danger of uncured photo initiators
- Reduced risk of fire of UV lines & reduced insurance premium.

Precise temperature regulation and hence constant equal glue viscosity is made available within the entire operation width.

Application roller must be alternatively chrome-plated or equipped with a hard rubber surface. Melting of glue must take place directly at the application machine or by an external barrel melting unit.

Tolerances within the core and

frame construction create counter forces against a proper glue bonding. Therefore, any door construction, including the frame, necessarily requires a flat press system, instead of a calander roller press system.

Door Finishing

For the coating of doors, furniture components, flooring elements, as well as wall and ceiling panels Bürkle offers a large range of roller coating and printing machines. In addition, Bürkle also offers different drying and curing systems with air jet dryers, UV (ultra-violet) dryers and IR (infra-red) dryers.

Now we are presenting a compact



Depending on the glue system, the use of chrome-plated doctor rollers or doctors with a hard-rubber surface could be used.

lacquering line, KA, for the application of the base coat and top coat onto flat furniture components, doors and components for interiors, using an innovative new drying technology UV-LED.

This new drying technology gives an idea of how UV-curing lacquer can actually be cured on "cold" work piece surfaces (max. 40° C) with a drastically reduced energy consumption.

In addition, this dryer offers further advantages such as a much longer service life of the light source, no forming of ozone and the fact that no extensive air cooling of the light source will be required any more. The use of this technology permits to treat resources with care and to significantly improve the working conditions of the operators.



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Felder Group: 'Solid' advice for solid wood doors

In the year 2000, with the starting of new century, Mr. Arvind Gupta started with the setup of his woodworking unit, Ishan Doors Industries, manufacturing solid wood doors, window shutters and frames.

He was constantly researching on the products' finish and quality, which led him to consider high-end production machines. It was in the year 2004, that he consulted the Felder Group. Acting on their suggestion and expert advice, he purchased a spindle moulder, his first machine from Felder.

"It was the time that changed our minds and the finishing impressed us. The precision, quality of machining and finishing is unmatched with any other machine in the range," Mr. Gupta says.

Later he relocated to a bigger facility in 2010, with a new name – Joss House Wood Products – through changes in Ishan's machining and wood processing techniques. Then he upgraded to chemical treatment and kiln wood seasoning.

Now JHWP produces doors, windows, designer shutters and frames with high finishing and has spread its network of work to major parts of northern and eastern Uttar Pradesh, some parts of Bihar and Uttarakhand.

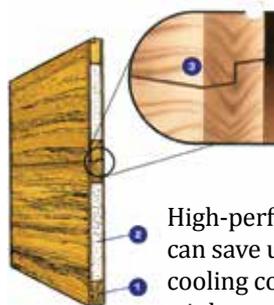
In the year 2014, he started a panel processing facility – Laminarts Décor Pvt. Ltd. – for manufacturing of modular kitchens, interior furnishings and furniture. He truly relies on Felder machines and services.

"It has been a long time since we purchased our first machine from Felder. To date they have always performed outstandingly, good service and customer satisfaction. I would say that Felder has always been a good companion for our machining needs," Mr. Gupta says confidently.

The international level quality and precision, individual solutions, stability and functionality of Felder machines have always inspired him for the accuracy and precision of his end products and customer demands.

Currently JHWP employs Felder's panel saws (K700s and K900), surface thicknesser (AD741), spindle molder (F700Z) and a multi-boring drill (FD969).

Did You Know?



High-performance vinyl windows can save up to 40% on heating and cooling costs. They are made with triple pane glass, reflective coatings of low-E, insulating glass, and air spaces filled with Krypton gas.



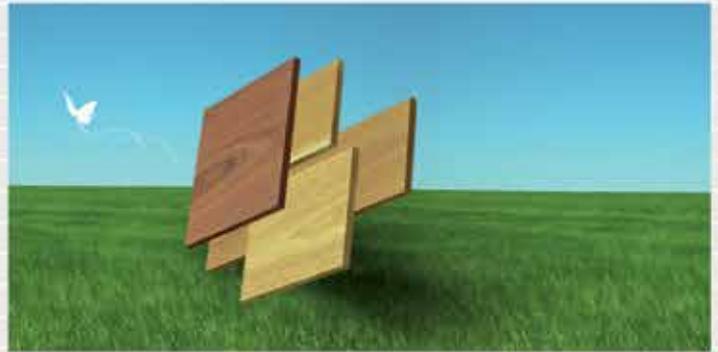
Shiplap joint provides a weather-resistant fit between sections to help seal out rain, wind and snow.



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Durian doors: durability & elegance

The epitome of elegance and durability, Durian doors are manufactured combining the best of both worlds: old-world craftsmanship and latest technology. Utilizing highest grade materials Durian doors are crafted with the utmost attention to detail to ensure the absolute quality and beauty of each piece.

The Durian door range exhibits the widest variety of styles, designs and materials that are sure to match every need, taste and style. Our door range comprises flush doors, moulded panel doors, PVC moulded panel doors and carved doors skins.

Durian holds a unique position in the market for many reasons, among them:

Ready-made doors: Durian doors are

supplied to the customer tailor-made, of the size preferred by the customer, which enables them to fit the door perfectly without cutting the doors from sides and top. This also increases the strength of the door as the doors frame is not cut.

Exceptional finish: Durian doors come with factory-finished polishing which is not achievable by hand, even at a very high cost.

Economical: When one makes a door locally by a carpenter, they end up buying the entire sheet of veneer (32 square feet) out of which only 21 square feet is utilized. This amounts to huge wastage, and the overall cost of the door becomes higher. Because Durian is a manufacturer of veneer, plywood and laminates, raw material

cost is something you do not have to worry about.

Hassle-free: Durian doors are easy to install as they are ready to fix. The entire process is completed within a day.

Solid wood: Durian uses only high quality pine wood to manufacture doors, which provides durability and strength to the doors.

Matching frames: Durian has introduced a unique concept of matching doors and frames which is completely modular, which is an ideal alternative to high cost and problems of job site painted pre-hung doors. Pre-fit, pre-finished and perfectly colour-matched doors and frames a must for any project.



Dorpan maker expands into Russia

Kastamonu, one of the global wood industry's largest manufacturers of wood-based panels, recently opened a new factory in Russia with \$260 million in investment. The MDF line has a capacity of 5,65,000 square metres per year.

A laminated flooring line with an annual capacity of 20 million square metres will start production by the end of the year at the same location.

The turnover of Kastamonu Integrated (founded in 1969 in Turkey) in 2013 rose up to \$1.2 billion, of which \$325 million was from exports to 70 countries across the world.

Its door skin brand, Dorpan, owns 40% of Europe's door skin production capacity and 10% of the world's. Dorpan panels (also widely available in India) produced with a wide range of model choices are supplied to the customers with double layer water-



based primer, which is suitable for all kinds of finishing paints and varnishes.

Dorpan's range of interior molded door facing provides all the beauty of solid wood with no disadvantages. Production of Dorpan door panels

are monitored in detail in all production phases and the whole process is performed in automatic lines supervised by high qualified personnel, in order to reduce variation of errors.

Dorpan has an aesthetic look with its texture of wood pattern with 14 different formed models: Anatolia, Aspendos, Assos, Perge, Simena, Side, Patara, Efes, Hitit, Artemis, Sumela, Olympos, Truva and Smirna.

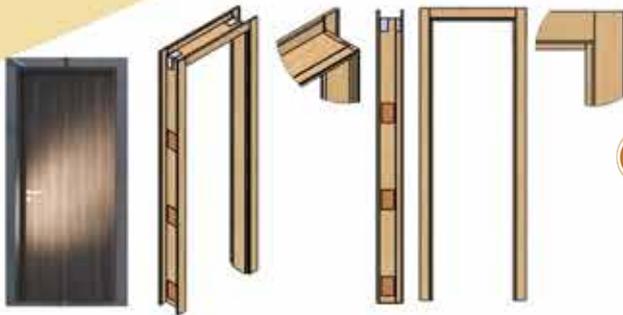
Kastamonu Integrated produces raw and laminated chipboards (Yongapan, Yongalam, Teknopan, Teknolam), raw and laminated MDF (Medepan, Medelam), laminate flooring (Floorpan, Artfloor), door skin panels (Dorpan), as well as related accessories.

The combined annual production capacities are 2.55 million cubic metres of chipboard, 2 million cubic metres of MDF, 60 million square metres of laminate flooring, and 17 million door skins.

What separates the inside from the outside...is often a Door

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Sauerland offers 40-44mm doors

Rising timber prices have shrunk the door thickness to a meaningless 30mm or 32mm. The real artistic beauty, richness, warmth and glamour of the door lie in a 40-44mm door shutter.

The world over, most commercial doors are of this thickness range. In India, however, builders shy away from the thicker door, as with primitive construction technology the cost exceeds 50% of the 30-mm thickness.



Now Sauerland launches a specially engineered door infill which enables door manufacturers to cater to the builders and architects' requirements at an incremental cost. A win-win situation now unfolds.

Sauerland has launched a 34-38-mm tubular board, which will be the heart of the 40-44-mm door with 3-mm skin on both sides.

The tubular infill boards are eco-friendly and a green product initiative, replacing 80% of timber used internally as door infill, which dramatically improves the performance

of the door.

Advantages

- Sound insulation ensures privacy of sight and sound, reduction of sound by 28dB
- Fire resistance of up to 20 minutes
- Security with an impact resistance of 20 kg/sq cm
- Thickness tolerance of +/-0.1mm, no telegraphing, no waviness
- Weight reduction of 40% over solid wood
- E-1 emission standard ensures doors are safe for indoor use
- PEFC certified means sustainable supply chain of custody
- Swelling in thickness – almost zero, long life for door.

Ebco range of fittings for Indian Doors

Ebco has a range of sturdy fittings especially made for standard, flush and sliding doors suited for Indian conditions. Here is a sample:

Sliding Door: Standard

- Precision roller system has good load bearing and life
- Has special guides and catches to secure the door
- Load capability of 125 kg
- Easy to install



Sliding Door: Flush

- Precision roller system has good load bearing and life
- Has special guides and catches to secure the door



- Special flush fittings to conceal gaps
- Load capability of 125 kg

Sliding Door: Glass

- Ideally designed for glass doors
- Precision roller system has good load bearing and life
- Has special guides and catches to secure the door
- Glass thickness from 6mm to 10mm
- Load capability of 125 kg



Door Closers

- Tested for 5,00,000 cycles
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- Door opening angle (maximum) of 180°

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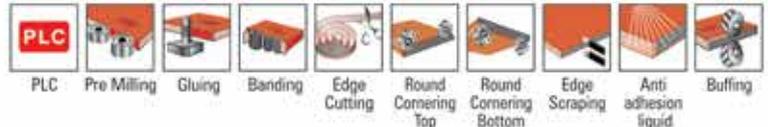


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J-3000.in (manual)
Curvilinear Edge Bander



Edge Trimmer J-3003R.in (manual) (Radius Trim)



Spirit of Excellence



ALL PARTICLE BOARDS ARE SAME!
ALL PARTICLE BOARDS MAY LOOK SAME!!
BUT ARE NOT THE SAME!!!

AS PER EN 312 BOARDS FOR FURNITURE AND
INTERNAL FITMENTS MUST BE OF TYPE P2

Particle Boards have set a revolution in the engineered wood panel trade since 1960 globally and in India post 1980's and the demand has escalated in leaps during this century. Particleboards are products of high technology and technical configurations and are highly performance oriented. Several furniture manufacturers are buying huge volumes of particle boards to process in their factories and the biggest challenge is to know if the buyer is paying for the quality for a board which looks more or less the same externally but internally has a large play field to be "tailored" by the manufacturer based on price demands of buyer. Some Questions and Answers to clear the mist around

Why is choosing the correct Particleboard important in determining the quality of your furniture.

Particleboard is an engineered product capable to last a decade withstanding the daily use abuse just like plywood if used of the right quality with the right Modulus of Rupture, Modulus of Elasticity and Internal bond properties. HeveaBoard specialized in producing Low Emission Particleboard which do not compromise on mechanical properties.

Why does door hinges loosen after some time?

Holding hinges is a property of the construction of the board. If the board has a low internal bond the hinges loosen within short time and can cause the shutter to come loose from the carcass.

Why does cabinet shelves started to warp after some time?

Sagging or warping by placement of any weight on the shelves is caused by the board having poor modulus of rupture. A poorly produced board can sag even by its own weight!!!

Why is my furniture made of particleboard swell?

Swelling is a natural reaction to moisture for any wooden product however the resin formulations inhibit swelling to large extent to less than 8% after 2 hours immersion. However compromise on the resin additives and formulations will cause reflection on furniture by display of the swelling.

Why are Bending Strength and Internal Bond of Particleboard important?

Bending strength and Internal Bond are the key engineered lifestyle properties of the particleboard which reflect like a healthy heart and a positive mindset in a human body. Poor properties mean premature death of the furniture.



HeveaBoard



HeveaBoard Quality vs Competitors.

eg. Bending strength of $>13\text{N/mm}^2$ vs 10N/mm^2 .

Internal Bond of $>0.35\text{N}$ vs 0.25N .

Thickness Swelling $<5\%$ vs $<8\%$

HEVEABOARD never compromises on quality and ensures the product at market prices at all times. It has dedication to uplift the falling standard of quality in the particleboard industry. All boards look same from outside to a furniture manufacturer and lack of the knowledge of cause and effects of the key properties on the life of furniture is rapidly earning a bad name for particleboard industry in India.



What is Formaldehyde?

Formaldehyde is a common precursor to more complex compounds and materials. When treated with phenol, urea, or melamine, formaldehyde produces, respectively, hard thermoset phenol formaldehyde resin, urea formaldehyde resin, and melamine resin. These polymers are common permanent adhesives used in plywood, ParticleBoards and MDF. Production of formaldehyde resins accounts for more than half of formaldehyde consumption.



Why is Formaldehyde hazardous to health?

Formaldehyde has been declared a known carcinogen chemical and for any indoor use the emission level is necessary to be below $8\text{mg}/100\text{g}$ oven dry board.

Why choose low emission Particleboard?

Low emission ensures the air quality has no toxic emissions from the furniture items. In India unfortunately the awareness of the formaldehyde emissions is too low. In EU all engineered board manufacturers have self imposed to produce only E1 norm as standard minimal emission and other countries too have similar or lower emission like E0 level board mandatory. HeveaBoard can supply upon request E0 as well as CARB P2 and F**** compliant particle boards.



HeveaBoard

BEWARE!! Do not fall prey to cheaper look alike boards which will fail in screw holding, load bearing and make you replace the furniture within few months. Laminated particleboards can be easily identified by HEVEABOARD stamp on edges. For Furniture buyers our channel partners can provide a certificate with shipment on the motherboard used.

Issued in public interest for well informed buying decisions by the furniture industry.

Insist on buying from our Channel Partners: Amazon Wood Pvt Ltd; Prism Laminates Pvt Ltd, Shell Laminates Pvt Ltd & Stylespa (Indian Furniture Products Ltd). **HeveaBoard** is looking to increase channel partners in India who share the quality commitment. For any information please contact : nvaze@heveamart.com

Jai's stable of work-horses for doors



 Basic CNC Router Model # J-1325 VT (A)

The basic CNC router (J-1325 VT) is used for engraving and designing of flush doors and kitchen shutters. Make your industry high-tech at an affordable cost; thanks to heavy ball screw drive with high accuracy. Cast steel structure makes Jai's routers more stable and auto lubrication makes maintenance much easier.

The router comes with a tool holding guide system, a precision system to carry the CNC design commands. This auto-sliding guide system allows great design flexibility.

The control system comes in a convenient, separate control panel box that allows flexibility and efficiency in machine operating. Digital signal processing is applied here as the controlling system.

The precision vacuum working table is for fixing and sure clamping of the work piece, to ensure steadiness during the entire routing operations.



 Vacuum Membrane Press model # J-1100.in

The vacuum membrane press (J-1100.in) is most suitable for flush door and shutter manufacturers used for applying a uniform lamination of PVC, decorative papers and veneer till 0.4-mm on top surface and borders on flat and designed work piece having smooth shape.

It gives highest quality performance and finish with high production output. High performing single and double trolley models are also available in J-1102.in, J-1250.in and J-1252.in models.

Advantages:

- Vacuum abnormality wrapping technology
- Lamination on one-sided prelam MDF / particleboard
- One set of tray minimized with machine for optimal usage of work tray
- Silicon membrane offered for veneer application on flat surface only

- Short pressing cycles
- Centralized control panel for controls & display
- Digital temperature controllers, adjustable timers for automatic cycle
- Work table with single side opening for easy loading
- Manual feed of tray for loading
- Special steel work table is proof against high temperature and corrosion
- PVC foil roll holder with stand.



 Hydraulic Hot Press model # J-120T1

The hydraulic hot press (J-120T1) is suitable for pressing and laminating on fibre boards, decorative papers, plywood and other lamination sheets. It can be used for particle / MDF / HDF boards.

The six heavy-duty, free-floating cylinders take care of alignment and for lifting solid steel platen for uniform pressing of work piece. Steel platen not only avoids breakage, but also easily clears the glue.

Advantages:

- Rigid construction to take care of thermal distortion
- Platens designed for uniform temperature distribution
- Manual & semi-automatic controls
- Specially designed high temperature oil pump for circulating the heating fluid

Technical data:

1	X-Y-Z axis working area	mm	1300 x 2500 x 200
2	Resolutions	mm	0.025
3	Spindle		5HP, air cooling, 18000 rpm
4	Drive motors		Stepper
5	Command code		G code
6	Computer interface		USB 2.0
7	Collet type & size	mm	ER25 (12.7,6,3.175)
8	Software		Type-3
9	Controls		Digital signal processor 0501

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BRANDT BRANDT NKD 720
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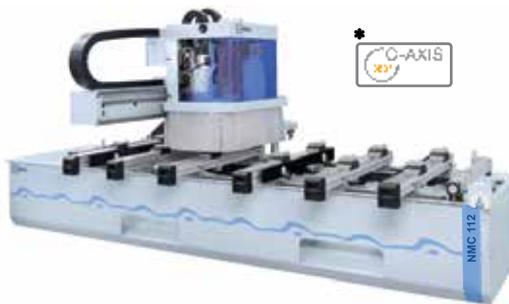
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- Graphic and tabular pressure charts
- Emergency stop controls.

Specifications	Unit	J-120T1	J-120T3
Maximum load / pressure rating	ton / kg-cm ²	120 / 3.6	120 / 3.6
Platen size	mm	2500 x 1300 x 42	2500 x 1300 x 42
Number of layers	nos.	One	Three
Opening between layers	mm	300	100
Number of hydraulic cylinders	nos.	6	6
Size of hydraulic cylinders	mm	100 Φ	100 Φ
Heating power	kW	24	48
Hydraulic pump power	kW	5.5	4
Hot oil delivery pump power	kW	1.5	2.2



Hydraulic Cold Press model # J-50T

The hydraulic cold press (J-50T) is suitable for pressing various types of laminations on composite wood, cork board, ply, MDF, fibre board or honeycomb board. It is used for various applications for furniture and

Specifications	Unit	J-50 T	J-80 T	J-100 T	J-200 T
Maximum load on work table	Ton	50	80	100	200
Platen size	mm	2500 x 1250	2500 x 1300	2500 x 1300	2500 x 1300
Maximum platen opening	mm	1000	1000	1000	1000
Number of hydraulic cylinder	No.	2	2	4	4
Bore size of hydraulic cylinder	mm	125	160	125	150
Installed power	HP	5	5	5	7.5

board lamination industries; mainly to press various glued wood parts in usual temperature.

Advantages:

- Good splicing effect & high efficiency
- manual & semi-automatic controls
- Rigid construction

- Emergency stop switch & limit switch
- Motor overload relay
- Platen designed to take heavy compression loads
- Synchronized gear bar for smooth movement with eccentric rollers.

Doors from Gujcon: variety & versatility

For many years, the style and elegance of flush doors have made them the obvious choice for countless homes. While giving exceptionally long service, they accentuate the beauty of homes.

Gujcon Doors & Windows manufactures flush doors as per Indian standards. A solid core wooden flush door consist of a block board core bounded with cross band and veneer faces constructed on both the sides.

Timber is chemically treated and vacuum pressured. This process

strengthens the timber by making it not only durable but also resistant to borer and termite attacks and fungal growth.

Wood is generally seasoned in automatic kilns or seasoning plants to substantially reduce its moisture. It is further bonded with phenol formaldehyde (synthetic resin) to impart boiling water resistance and hot-pressed under uniform pressure. Decorative veneer or laminated sheet is pressed by melamine or PVAc resin. At Gujcon, each flush door is processed using advanced machinery

to keep the structure perfect and dimensions accurate and stable. To eliminate telegraphy impressions, the board is passed through a belt sander machine, which imparts super smooth finish.

Final finishing is done with commercial, natural, recomposed or decorative veneer. Such doors can be laminated or painted or polished on both sides.

Veneer Doors

Gujcon also manufactures Masonite's line of wood veneer doors, offering visual beauty and refinement of

SPECIAL FOCUS DOORS



Gujcon Flush-Door



Gujcon Moulded-Door

natural wood doors. All flush doors are available with hollow or solid core construction and matching bi-folds.

The finish is a precise simulation of authentic wood grain. Protected with a high quality topcoat, these doors are extremely durable and simple to maintain. They are also available in matching bi-folds.

Hardboard doors are perfect for small budget renovations. They come in un-primed, primed and subtle wood grain finishes. The entire flush door series is available in a variety of core options to suit any application. From hollow core to fire-rated, these constructions offer a range of benefits.

Hollow core doors are used where light to medium duty requirements are needed, or where weight is a factor, as in normal residential and office applications.

The stability and durability of particleboard core doors makes them outstanding for general applications. They are available in 1-3/8" or 1-3/4" thickness, with 20-minute fire rating.

Doors from wood stave cores are used in high use areas, where durability is required: industrial, commercial and institutional applications. Wood stave cores provide superior vertical stability, screw-holding strength and easy machining for commercial hardware applications.

They are available in 1-3/8" or 1-3/4" thickness and with 20-minute fire ratings (1-3/4" only).

Bi-fold Doors

Gujcon also manufactures mineral core fire doors in 45-minute, 60-minute and 90-minute fire ratings, for applications requiring a flush wood door rated to meet specific code requirements (available in 1-3/4" only).

To keep a consistent look throughout the home or office, the decor can be enhanced with matching flush series bi-folds. Bi-folds are a great space saving option when there is not enough room for a swinging door. All bi-folds come with the necessary hardware for installation.

Shree Gujarat Timber Corporation is a well-known enterprise engaged as a manufacturer, exporter and supplier of a versatile range of doors, windows, frames and shutters.

The main strengths of the Surat-based (Gujarat) enterprise is high-class quality products, top-of-the-line design and advance technology used in manufacturing a range of architectural doors. For more, visit www.gujcon.com.



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6. Wood working machinery
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8. Advance paid towards factory and showroom premises
9. Our background support for 6 months from takeover of the business.

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A revolution in coating



When Kleiberit introduced its patented HotCoating technology at Ligna 2011, it took the wood industry by storm. *WoodNews* corresponded with its inventor and Kleiberit's co-founder, **Mr. Klaus Becker-Weimann**, to find out more...



 *Kleiberit's high-gloss surface coating has a global footprint.*

What are the advantages of Kleiberit HotCoating? What are its applications?

The biggest advantage is the outstanding adhesion on almost any kind of substrate. Where there are many different substrates which are supposed to be 'uncoatable', the PUR HotCoating gives a long-lasting bonding without pre-treatment. So the application on melamine, glass, PMMA, PVC, PET, PE and aluminum is no longer critical. The application is by roller-coater. Spray application will be available in the near future.

How has the industry responded to it? Has it achieved the market penetration that you had expected?

The response after the 2011 Ligna show was excellent. The technology got tremendous attention from the global board industry. In less than 3 years, we are happy to announce more than 30 PUR HotCoating installations across the world.



Physicist, innovator and inventor, Mr. Klaus Becker-Weimann, who is also co-owner and Chief Executive Officer of Klebchemie.

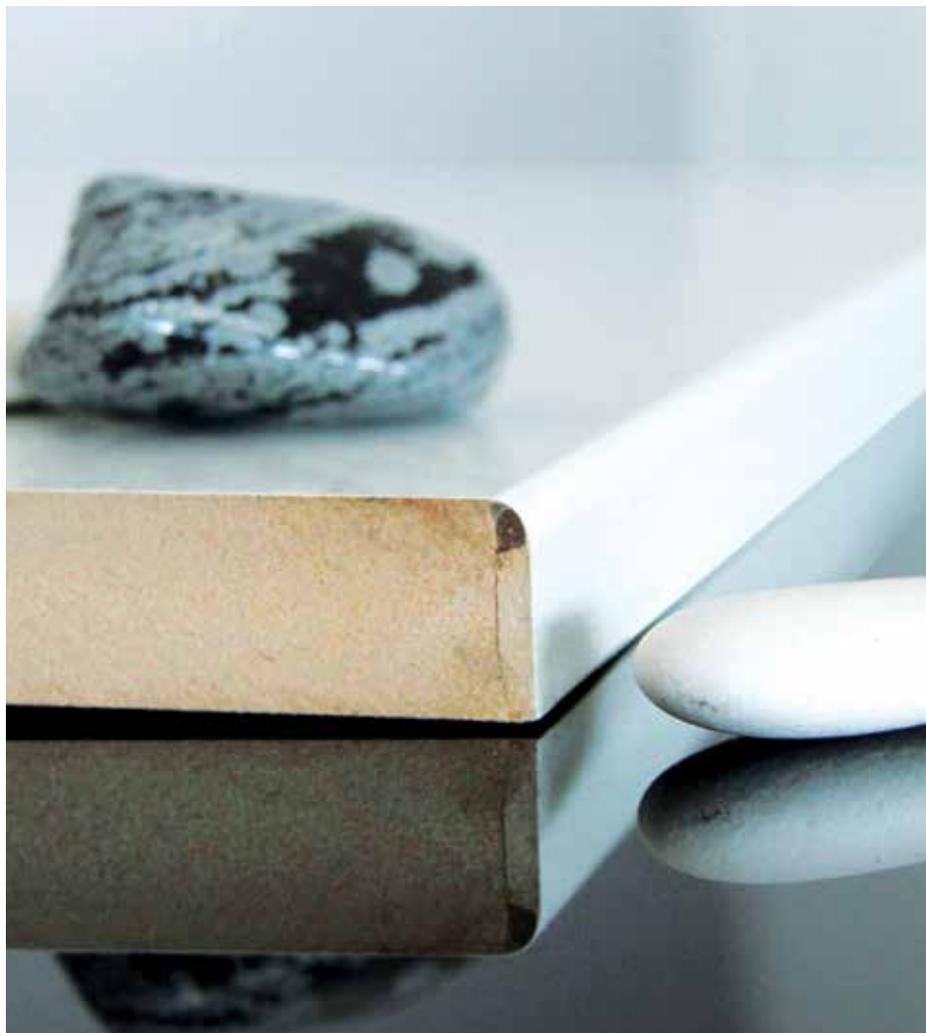
How reliable is bonding technology in the production of doors, windows, furniture and stairs made of solid wood? What are the best adhesives?

Kleiberit is a market leader in adhesives for window production. No other product is more strictly regimented by norms and the law than windows. Kleiberit offers a wide range of products to these applications and also very interesting solutions for bonding, mounting and manufacturing windows, doors, stairs or even furniture.

Our experience, the reliability and quality of Kleiberit products in this market is well known for generations and they meet international standards and normative requirements. As one of the leading companies – especially in developing and manufacturing reactive adhesive systems based on polyurethane (PUR) – you can be sure that our slogan, ‘Competence PUR’ is not only a promise, but the best way to produce high quality end products.

You are an inventor with over a dozen patents to your credit. Which would you rate as your greatest invention?

The PUR HotCoating related patents are, of course, of high importance for our global future growth. That said, we do believe that we have not even discovered 1% of the real possibilities and demands of this process.



Kleiberit's coatings hold an edge over competition on account of its design versatility.

How do you minimize the health hazard and increase environmental sustainability?

We live by the principle of sustainability in processes and procedures, according to certified environmental management. Responsibility towards environment and the people in research, development, production and logistics is one of our main goals.

What opportunity does India present to your organization?

India is an important part of our global expansion strategy. We take India as a very important market, with 1.3 billion citizens living and consuming within a border- and tax-free area. We appreciate the business manners of

our reliable Indian customers and we appreciate the continuous progress in technology and infrastructure we noticed in the last decade. That is the reason Kleiberit already has a full dealer network in India.

What are your top selling products in India?

PUR Hotmelt, EVA, PUR-foam... all our products are selling well in India. Moreover, we are happy to introduce PUR HotCoating and our industrial coatings very soon to the Indian market. Therefore our warehouse in Mumbai is of essential importance to ensure local availability.



German leader buttresses Swiss brand

Wemhöner, a market leader in short-cycle press lines, helps Swiss Kronospan churn out high-quality melamine-laminated boards



View into the stacking station of the short-cycle press.

Products with the label 'Swiss made' enjoy a high reputation. Kronospan uses Wemhöner technology to produce, among others, furniture panels and floors. The latter is a family business for nearly 90 years and is a market leader in the design and delivery of short-cycle press lines for melamine film lamination.

The turnover of Wemhöner in 2013, for the first time in its history, crossed €100 million. Wemhöner Surface Technologies GmbH scores with its overall concept of the line and its specific features to produce flooring and furniture panels with synchronous pores, and in trendy colours.

For this specific use the intermediate paper magazine is designed in a way that it can feed the three lay-up stations without loss of time. One of the lay-up stations is equipped with three daylight, the two others with two.

This takes care directly of the production line to ensure that the film

structure can be programmed quickly and easily, especially at top and bottom, and change can be easily performed. This ensures, directly at the production line, that the film composition top and bottom can be programmed quickly and easily and changes can easily be performed.

The lay-up accuracy of the décor papers for embossed-in-register printing is stated with +/- 1.0 mm. The correct position of the decorative films is checked and aligned with a special camera and alignment system before feeding into the short cycle press with a special camera and alignment.

The tolerances (both in length and width) that will arise through the printing and impregnation of decorative films are also recorded via this system and automatically transmitted to the press.

Versatile System

The raw boards are fed into the line from the raw board magazine with

six in-feed and two residual board positions via gantries with vacuum suction cups, after passing a brush cleaning station. The lengths of the work pieces can range from 2,500mm to 3,250 mm. Maximum width is 2,070 mm, and the minimum thickness 4 mm.

The maximum thickness varies according to the substrate: for particleboard it is 50mm, for MDF it is 40mm, and for HDF it stands at 20mm. The special lay-up concept mentioned above makes it possible for the raw plates to be transferred at all three places next to each other.

Thus, even products with different decors can practically be produced next to each other. Lot sizes as of five boards are intended for use at a time.

The short-cycle press 'KT F-1E' is at the heart of the system. Production of this type of press is one of the absolute core competencies of Wemhöner. The '12 cylinder' builds up a specific pressing pressure of 700 N/cm² with which





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deep structures are possible in the embossed-in-register mode.

But that was only one side of the coin with Kronospan. Equally important to its engineers is the homogeneous pressure distribution. It has the decisive influence on the result if, for example, solid colour papers should be pressed in the currently trendy intensive colours.

At uneven pressure build-up slightly milky looking areas would arise at the surfaces. This is not an issue with the uniform pressure achieved by the Wemhöner short-cycle press.

Heating Technology

However, such surface defects may also arise if the press plates are not exactly straight. This happens whenever it comes to temperature differences within the press plates. These temperature differences lead to a curvature – even if only in the mm range. This can be noticed even with a heating plate size of 3450 mm x 2200 mm.

Wemhöner encounters this phenomenon with a clever heating technology which takes care that the temperature is correct as of the first plate. The upper and lower heating plate can be heated with two separate control circuits, which provide for always constant and uniform temperatures on the one hand with the main heating at the caul plate and on the other hand via the counter-heating in the heating plate.

The intelligent control technology ensures that the temperature losses arising at the time of emission of the heat to the substrate are compensated within seconds. This is technology at the highest level, because Wemhöner tackles up to 240 press cycles per hour in standard or 180 in the synchronous mode.

To reach these values, even the pressure-less time is of importance, which is also short. If it is too long, optical defects of the surface can

occur. So speed is also a topic here. Wemhöner uses highly dynamic servo drives.

Perfection Achieved

Of course the quick change of lay-up stations cannot be transferred to the same extent on the exchange of the caul plates. For this a greater effort is needed. But the time of 10 minutes for a caul plate change is still quite impressive.

The procedure is relatively simple in that the press plate magazine is placed right next to the press and the change is performed automatically to the last manual step at the heating plate itself. The number of 40 daylight for the caul plates illustrates the variety of options.

After emerging out of the press the narrow edges of the pressed boards are trimmed by an edge trimming unit. For processing the narrow edges, the line is stopped for a short time. The longitudinal edges are processed in through-feed operation.

After cleaning with rotating counter-moving brushes from above and below the work pieces are raised through a gantry. This process is timed in a way



The short-cycle press 'KT F-1E' is at the heart of the system. It is a high-pressure system (700 N per square cm) with EIR technology.

that a brief visual inspection can be made.

Then there are three possibilities: either a direct discharge to the six stacking positions at the end of the production line takes place. Or the work pieces run through the two-board cooling devices each with 44 compartments.

Moreover, the boards can be discharged and carried to an intensive control if a more detailed inspection of the surface is necessary. A board turning devices allows for inspection of the top and bottom surface.



Board cooling station with double sided intensive inspection.



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One more 'line of log carriage' from Barton in India



This 'line of log carriage' in Gandhidham is for pine wood.

Barton has added one more step in its journey in the Indian market with the installation of complete 'line of log carriage' (LLC) for Navkar Enterprises in Gandhidham, Gujarat. This time the LLC is for pine wood.

An LLC is a customized sawmill, complete in itself, with only one operator required.

The operator can handle all the work, from log cutting to making final production of planks or slabs. It sends firewood out of the process and concentrates on getting high production with accurate dimensions of planks.

Navkar Enterprises is in the market of Gandhidham from the last 16 years, having a saw milling business in Assam. It procures Radiata pine from New Zealand and southern yellow pine from North America.

Barton already has many more lines

of LLCs in India for other wood, for different lengths and diameters of logs. The LLC for Navkar Enterprises is for 4-metre-long logs and for cutting pinewood with maximum diameter of 80 cm.

They are basically focused on making planks for pallet industry, where the accuracy is most required. Navkar Enterprises had faith in Barton in 2012, when it firstly installed 'double horizontal' machines with return system for re-sawing of slabs.

After the success of that machine, Navkar again placed its trust in Barton and immediately sensed the need of an installation, where the company could cut logs too. Today the company possesses a complete sawmill where it employs optimum manpower, accuracy and thin kerf technology.

When one talks about a complete LLC, we talk about a complete solution for

a sawmill, which comprises of:

Automatic chain in-feeder:

Here, 15-20 sectioned logs can be loaded, so that the operator will be carrying logs one after another for production. It is operated from the operating seat.

Pneumatic operated loading system:

The equipment for loading the logs one by one onto the log carriage, which has placating arms for support, is also controlled from the operating seat.

CPTN-3A4-Ecobar:

Is the log carriage with independent head blocks and electrical movement. The Ecobar system incorporates numerous advances in the process of sawing which gives great speed and best yield of raw material.

With the help of log turners, the operator can turn the log for searching the best first cut and after that as

CASE STUDY BARTON SAWMILL



 An LLC is a customized sawmill with only one operator required.

many times as he requires for cutting the logs. Automatic alignment is possible, which helps in taking the best yield of the logs.

A measuring system with touch-screen is available with different programming available in it for different patterns of cuttings for different logs. Profile scanning, measurement of volume and cutting pattern of log is done via a 2-D system.

Chassis:

A robust structure of chassis, where log carriage moves on rails while cutting, works for years.

Band Saw SCB:

Is a vertical band saw with double side cutting in the same band saw, which helps increase production by up to 40%. The band saw includes an evacuation chain for the planks and slabs. Lubrication of the band saw blades works with a timer.

Sliced wood parking:

Conveyor of chain for sliced wood, which is useful for re-sawing of slabs cut in the band saw of log carriage.

Cylindrical output:

A retractable section of rollers is employed to allow downfall of firewood, situated just after the band saw.

PVC band conveyor:

The longitudinal conveyor is integrated under the roller of log carriage for evacuation of firewood and corners.

In the current scenario, where competition is increasing by the day, installation of LLCs is a perfect solution for getting more yields from the logs, when accuracy of final product is more important, and when the new generation of saw millers is searching for solutions to working costs.

Running cost of a sawmill is a vital factor, and hundreds of workers in a sawmill in the traditional manner are not helping improve profitability. Senior technicians from Barton install the line, and give intensive training to the workers at the mill.



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Fevicol Adhesive Solutions for Woodworking Applications



Fevicol Hotmelt Products

Fevicol's range of edge banding adhesives has several options for manual as well as automatic machine application. All options provide good adhesion properties with good resistance against heat, cold, moisture and oxidation.

Hotmelt 380 (unfilled) and Hotmelt 388 (filled) are Ethylene Vinyl Acetate (EVA) based thermoplastic adhesives recommended for through feed edge banders. They can be used with PVC, PP, ABS, veneer, polyester or melamine resin edge bands.

Hotmelt 382 is specially designed for manual edge banding machines. It can be used to apply PVC, HPL, ABS or solid wood lipping onto MDF or particle board.



Fevicol SWR Range

Specially designed for the handicraft industry, this Polyvinyl Acetate based white adhesive meets the DIN EN 204 Stress Group D3 Standard. It is suitable for all types of wood working applications and provides very high water resistance and excellent bonding in lamination with all grades of wood, even in high humidity areas. Fevicol SWR Plus is specially designed for application in cold weather conditions. SWR EQ has even better cold weather performance and can achieve D4 standard by adding 5% isocyanate. SWR LV has very low viscosity. All are non-flammable and non-toxic with REACH Compliance, Low VOC (Volatile Organic Compound) Certification and Free Formaldehyde Certification.

Fevicol PVC Fix

This water/synthetic resin based emulsion adhesive is suitable for lamination of primer coated PVC sheet to MDF. It is also used for manual edge banding of primer coated PVC Strip to MDF, particleboard, ply etc without using any edgbanding machine, making it highly economical. It has excellent bonding compared to solvent based adhesives, as well as high heat resistance, easy applicability and low VOC



Fevicol SH

The classic PVC white glue for wood to wood bonding features unsurpassed bonding strength, good resistance to water and heat, higher coverage and good value for money. It is not only a leading brand in India, but also the most successful brand in the world in this segment, being exported to over 50 countries.



Fevicol SP Range

This range of sprayable, synthetic rubber based solvent borne contact adhesives can permanently bond painted steel, plywood, chipboard, PU foam, muslin, foam rubber, felt, fabric, leather or many other materials. SP-4 is the basic version. SP-5 is specially designed for the automotive industry and is also used to make writing boards using honeycomb cardboard and white laminates. SP-6 also has high heat resistance.

Membrane Press Range

Fevicol Membrane PU is a solvent based polyurethane contact adhesive used to bond PVC foil to MDF, plywood or other materials. It is ideal for door manufacturing, with low activation temperature, fast drying time and good bond strength.



Fevicol Membrane Press Star 2K is a two-component water based synthetic adhesive used to bond PVC film laminate to wood based panels in the modular furniture, modular kitchen and doors industries. It has excellent heat resistance, low activation temperature and high green tack. It is non toxic and non flammable.

Fevicol Heatx

Fevicol Heatx is a synthetic solvent-borne rubber-based adhesive made with a special formula with excellent heat resistance of up to 170 degrees Celsius. It also possesses quick grab property and strong bonding efficiency. It comes in 1 litre and 5 litre packing.



It is used in bonding challenging substrates like PVC foam sheet, WPVC, UPVC sheet to Mica, PVC film and veneer.

However, some precautionary measures have been recommended by the manufacturer:

- Bonding surface has to be sanded using No. 80 ambar paper or any handy sanding machine
- After cleaning the surface, Fevicol Heatx should be spread in one direction only
- Wait for 7 minutes to remove solvent for the adhesive system
- After joining both substrates, apply pressure using hammer strokes on wooden patti for strong contact
- Remove excess mica or PVC film using knife or trimmer after 5 minutes
- Initial bonding takes 3 hours; final bonding strength comes after 24 hours
- The same process can be used in roller press machines for faster production

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Focus shifts to 'smart' homes



Scenes from FMC China 2013.

'Furniture Manufacturing & Supply China 2014' (FMC China 2014) will be staged at the Shanghai World Expo Exhibition & Convention Centre (SWECC) from September 10-13, 2014, and held concurrently with 'FMC Premium 2014'.

The total floor area will be 59,000 square metres and the event is expected to attract 850 exhibitors. With associations and pavilions at home and abroad expanding, FMC China 2014 will inaugurate a new look with a special area for exhibits.

This will contain the following areas: woodworking machinery, CNC machinery, upholstered furniture machinery, coating machinery, furniture adhesives & coating machinery, office furniture accessories & components, furniture hardware & fittings, wood & surface décor, and furniture fabric & upholstery components.

Each special area is ready for the show. FMC Premium 2014 booth sales are over 80%. pavilions from France, the United States, Canada, Germany, Malaysia and some other countries all confirmed. The leading enterprises in CNC machinery are coming in large

numbers.

At the FMC China's 20th anniversary, the 2014 China Upholstery Industry Development Forum will be specially held onsite. The upholstery market is just getting started in China, and its huge development potential has attracted numerous manufacturers.

Most industry leaders and experts will be invited to share the top intelligence in the industry. FMC China 2014 will build a bridge between upstream and downstream businesses, encourage cross-border cooperation and create the most influential industry exhibition in China.

Conference on Coatings

As the most significant mission in the energy-saving domain in China, not only VOC (volatile organic compounds) emission standards in a variety of typical industries will be published and be used for determining pollution fees, but also new discharge permits will be issued. Based on this specific policy, the key is VOCs emission and the resolution is the water-based paint in the future.

FMC China 2014 will follow policy variations and invite experts and

CEOs of famous furniture enterprises to share their successful experiences of VOCs emissions. The summit conference will clarify the mission of energy-saving and analyze the feasibility of environmental aqueous furniture.

It will also serve to communicate on VOCs emissions and aqueous paint for the furniture enterprises, as well as help the furniture enterprises become involved in environmental production industries.

At the very beginning of 2014, the tycoon of SE, Google, purchased a new smart home furnishings company, Nest, which ignites the fire of smart home furnishings. What kind of variation would happen in the future and what kind of influences might arise in the home furnishings industry?

With the development of high-technology, a new, comfortable, convenient life approached, which had altered the traditional approaches, has been bringing a better environment to our life and work. Take the chance to attend this conference: it will supply you with a number of actual solutions! For details visit www.fmcchina.com.cn.

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Awards galore at Xylexpo 2014

44,000 visitor count re-establishes trade show as Italy's mainstay



Winners of various awards in four separate categories were chosen by visiting journalists at Xylexpo 2014.

Homag Group bagged the first place in the 'Innovation' category at Xylexpo 2014. It was rewarded for its capacity to innovate both big 'batch one' lines and standalone machines, for the implementation of revolutionary technology (such as laser edge banding), while ensuring utmost user-friendliness and great attention to "green economy" topics.

The Biesse Group was placed second for its constant commitment to working centre innovation, characterized by some significant steps, such as the invention of "multi-center" for window production, or more recently, the 'AirForce' hot-air edge banding method.

In third place was Cefla Finishing for proving excellent capacity to apply innovation in digital printing processes and "poor" surface finishing, with the "Inert coating" and "Fusion coating" technologies.

Other awards went to IMA, Salvador, Greda, Wde Maspell, Weinig, Baumer, Buerkle, Cehisa, CMC, Texpan, Essetre, Finiture, Hans Weber, Holz-Her, Leitz, Siempelkamp, Superfici-Elmag,

Uniteam and Vitap.

The Acimall President, Mr. Lorenzo Primultini; the Eumabois President, Mr. Ambrogio Delachi; and Acimall's Director, Mr. Dario Corbetta, announced the winners and gave away the plaques.

Visitors Rise

Many fears that loomed on the eve of Xylexpo, the biennial international exhibition of woodworking technology and furniture industry supplies – held at the Fiera Milano-Rho Expo Centre from 13 to 17 May, 2014 – vanished into thin air as soon as the gates opened.

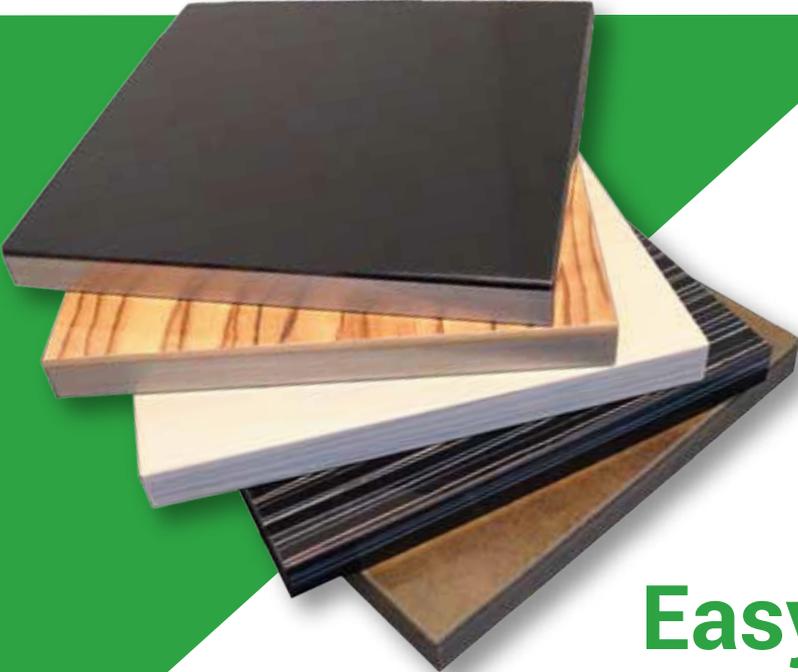
From the first day, it was clear that the event had preserved its role of reference international exhibition in even-numbered years: the flow of international operators was sustained and further consolidated in the subsequent days. Towards the end there was a "rally" of Italian visitors.

Although the Italian market is still facing serious difficulty, the exhibition reaffirmed its international scope and attractiveness for the industry.

Now in its 24th edition Xylexpo made all the necessary efforts to be a "key reference" for exhibitors and visitors. Regular registrations by professional visitors were 15,250, up by 7.1% compared to 2012. Attendance from Italy increased (4.6%) and even more from abroad (8.5%). Excellent results were recorded by continental Europe (12.7% increase in professional visitors), Africa (16%) and the Americas (1.8%).

On the contrary, visitors from Asia decreased (1.5%). In terms of total attendance – indicating the total amount of people entering the expo centre each day – the five-day result was 44,000 with a 42% share of foreign operators.

Xylexpo 2014 hosted 440 exhibitors, in three halls, covering a net exhibition surface of 27,000 square metres: there were 123 exhibitors from 27 foreign countries, with Germany in the first place, followed by China, Spain, Austria, the UK and the Czech Republic.



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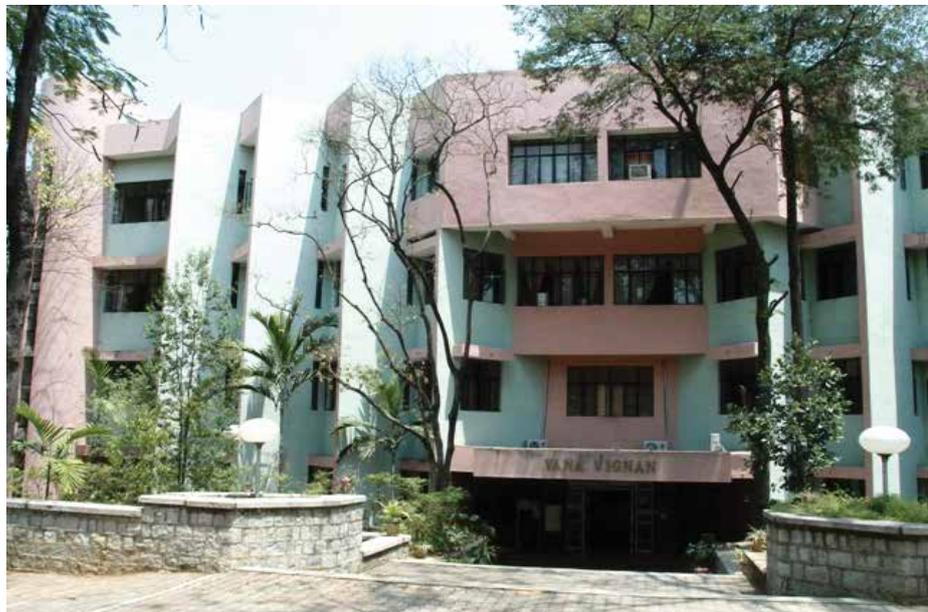


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Advanced woodworking course at IWST



The Advanced Woodworking Training Centre (AWTC) was started in the year 2003, as an Indo-Italian joint project between the Institute of Wood Science and Technology (IWST), Bangalore, under ICFRE, Italian Trade Commission (ICE) and the Italian Woodworking Machinery and Tools Manufacturer's Association (ACIMALL). The centre is situated on the premises of IWST.

The centre's intake capacity is 20 and minimum qualification required is SSLC degree with knowledge of English language. More than 95% of trainees get recruited in various woodworking industries across India. The course fee for above mentioned programme is Rs. 4000 and Rs.1000 is the charges for hostel accommodation, which is to be paid at the time of admission. Food charges are borne by the trainee.

Four weeks training, comprising three modules on a continuous basis throughout the calendar year, is offered.

Module I: Fundamentals of woodworking (1 week)

Module II: Basic mechanical wood processing (1 week)

Module III: Advanced mechanical wood processing (2 weeks).

While the training of Batch 91 is already under way, Batch 92 is scheduled to start on 21 July, and Batch 93 will begin on 24 August, 2014.

CNC Training

To update with the emerging



technology demand from woodworking sector, the centre is also equipped with a CNC (computer numerically controlled) router machine (Rover A3.3), supplied by Biesse of Italy. The intake for this course is five students.

The course fee for this programme is Rs. 8,000 and Rs.1,000 is the charge for hostel accommodation, which is to be paid at the time of admission. Food charges are borne by the trainee. The duration of the training is two weeks.

The course content is:

Module I: Fundamentals of CNC router

Module II: Basic programming & CNC router operations

Module III: Advanced programming & operations.

For details contact the Director, IWST, 18th Cross Malleswaram, Bangalore-560003 (Tel: 080-22190100) or email dir_iwst@icfre.org. Alternately, you may contact the officer in-charge, Advanced Woodworking Training Centre, IWST (Tel: 080-22190146) or email hsshahi_23@yahoo.co.in.



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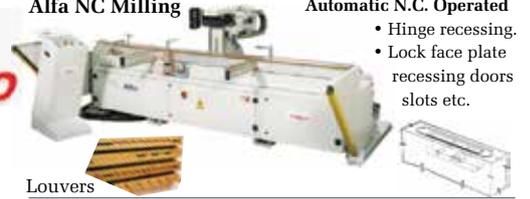
HTZ-800



Sliding Table Panel Saw

Spindle Moulder

Alfa NC Milling



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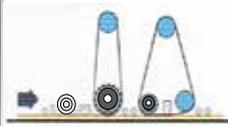
- Hinge recessing.
- Lock face plate recessing doors slots etc.

Louvers

SANDING MAX



Wide Belt Sander



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Multiple Rip Saw



Straight Line Rip Saw

Automatic Through Feed Edge Banding (Compact Machine)



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Manual Edge Bander



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Band Saw Blade Grinder

Three Head Multi Boring Machine



Hydraulic Hot Press 1/3/5 Day Light



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'Tulip Bar' turns a social hub

AHEC teams up with architect, sculptor to re-use tulipwood



For this year's Salone del Mobile in Milan (Italy), the international and influential style magazine Wallpaper returned to Leclletico Gallery with the fifth edition of its 'Handmade' exhibition, showcasing specially commissioned works and one-off collaborations between the world's best designers and craftsmen.

As a long-term supporter of Wallpaper's exhibition with a growing archive of handmade projects with aberrant architects Sou Fujimoto and Adam Khan, the American Hardwood Export Council (AHEC) teamed with award-winning British architect, Carl Turner, and sculptor Adam Kershaw to design a hub for a hotel's 'Lovage' juice bar, to serve a range of fruity cocktails at the Milan exhibition.

The starting point for the project was the decision to recycle material from AHEC's collaboration for Wallpaper's Workspace exhibition in 2013. 'Octopus', designed by Adam Khan and built by Adam Kershaw, was a series of striking timber walls made of contrasting dark heat-treated with raw light-colored tulipwood.

The installation was immensely successful and was subsequently re-used for nine other exhibitions and events including Interzum at Cologne, Buló's showroom, WoodExpo in Belgium, the Wood Awards Ceremony, and the London Fashion Week.

The tulipwood was re-purposed to build the Tulip Bar for the Salone del Mobile. To minimize waste, Carl Turner

divided each board into equal timber slats, presenting them in different guises – patterned transparent edges and solid surfaces – thereby creating a lightweight set of hollow units or 'bridges' that were arranged to form a continuous structure that weaves into the exhibition space.

Benches and a high table at either end of the bar provided a social hub and supported the bar unit, which bridges between the two benches. The multi-purpose surface broke the traditional barrier between the person behind the bar and the customer, and the two benches stretched out towards the rest of the exhibition like open arms, welcoming the guests.

Adam's role as the fabricator was





Last year's winner of the CID Award, 'The Hub'.

CID contest announced

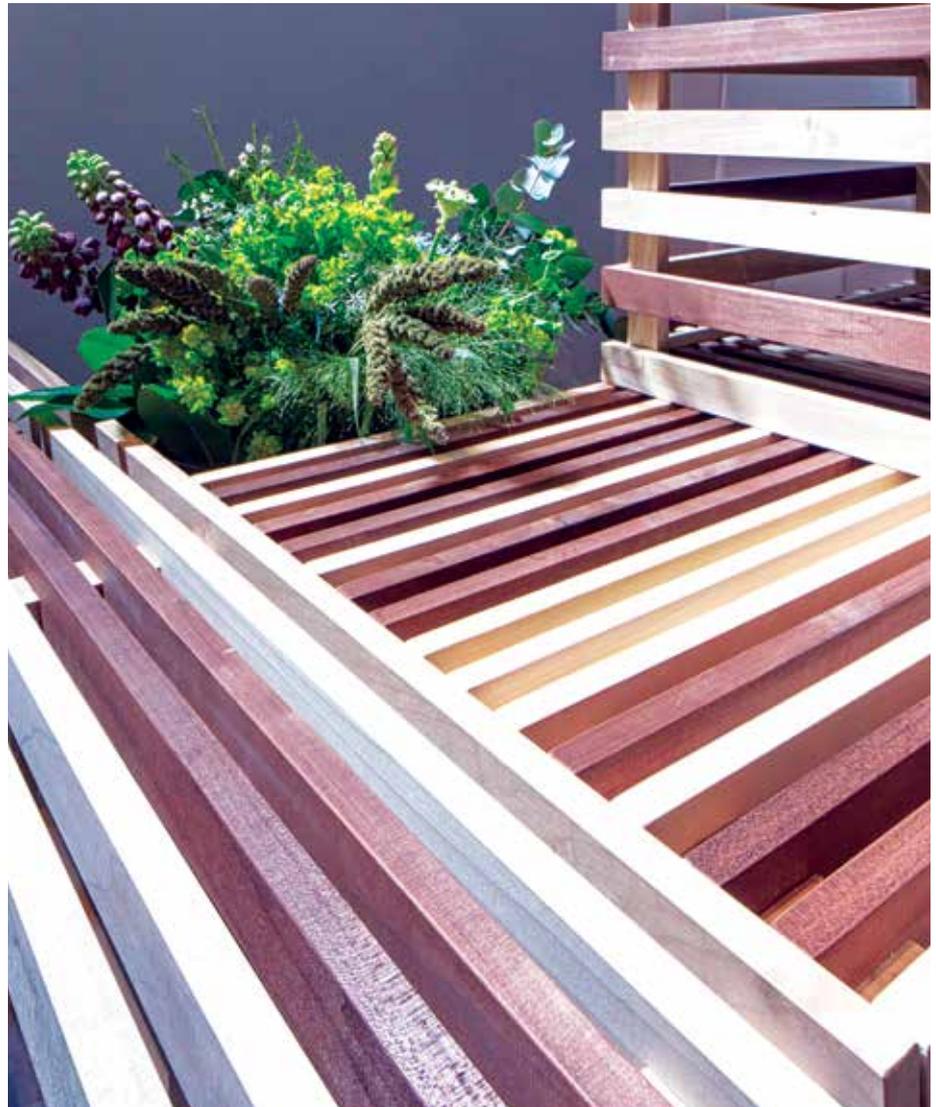
AHEC has announced its support for the eighth edition of the Commercial Interior Design (CID) Awards, which will be held on September 15, 2014, at the JW Marriott Marquis in Dubai.

AHEC is sponsoring the awards for the fourth year in row. It is open to any project with the only criteria being that hardwoods are an integral part of the project. Spanning 15 categories, 11 reward projects are from hospitality to offices, while the remaining four are designated for individuals.

This year, a new category – 'Interior Design Boutique Firm of the Year' – has been launched and will go to the interior design firm with a staff of less than 20 employees that has completed the most impressive work in the past 12 months.

AHEC Regional Director Roderick Wiles says: "I think it is terribly important for major players in any industry sector to recognize and reward excellence. This leads to healthy competition and higher standards overall."

The CID Awards provide just that: a platform to champion all the good work that is being done in West & South Asia, Oceania and Africa. For details, visit www.americanhardwood.org.



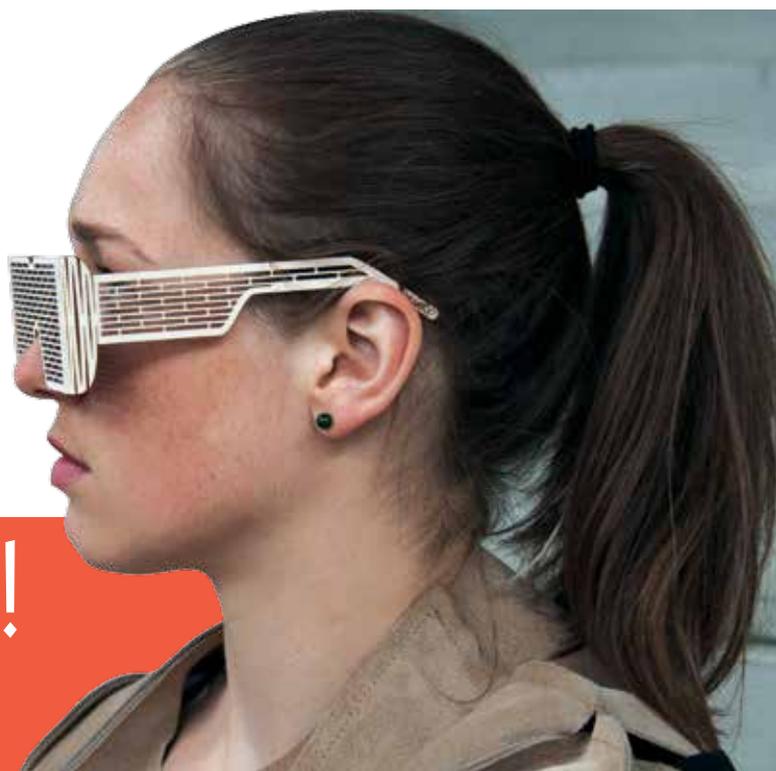
to find a simple structural solution to working with only one timber dimension. Reworking the components of the 'Octopus' made in 2013 was rewarding for Kershaw as the transformation was ultimately so economical. "I spend a lot of time using reclaimed materials, so it's an interesting twist to recycle one's own work," said Kershaw.

According to Roderick Wiles, AHEC's Director for Africa, West & South Asia and Oceania, tulipwood is very strong for its relatively light weight and was the perfect material for this project. The slats of dark thermally modified tulipwood become a solid surface for the counter top and the space below is used for storage.

"For a bar area that is prone to spillages, the timber is perfectly stable, and being a darker colour, it will not stain," concluded Wiles.

AHEC is the leading international trade association for the US hardwood industry, representing committed exporters among US hardwood companies and all major US hardwood production trade associations, and promotes US hardwoods in more than 50 export markets worldwide. (www.americanhardwood.org).

Going Dutch with wood SUNGLASSES!



Designers Quinten Peuling and Wisse Trooster are greatly inspired by modern production techniques, such as laser cutting and 3-D printing. Soon after graduating from the Eindhoven University of Technology (the Netherlands), they established their workshop, qoowl, and began exploring the limits of several materials with the help of these techniques.

From an early stage in the design process, the challenge is taken by qoowl to exploit the properties of materials. As can be seen in one of the first products – the 100% wooden sunglasses – aside from the basic materials there are only a few additions needed, which results in efficient production.



“We challenged ourselves to make a functional product from a single sheet of plywood by experimenting with the qualities and properties of the material,” the duo from the Netherlands says. This resulted in ShadE, the first 100% wooden sunglasses!

Without any additives or supporting

materials, the glasses are made from a single sheet of plywood and weigh only 14 gm. The packaging is made with the same principle in mind: a sheet of cardboard of one piece without any glue.

ShadE is produced with a laser cutter. After the cutting, the wood is sanded, then the glasses are bent so they will stay put. Owners can even wear them over their regular glasses!

“We try to reach a certain awareness among the people that get in touch with our products. At first glance it’s difficult to understand the essence of our products. Therefore a second look or thought is required,” the designers say.

(www.qoowl.com).

Like salt is to pepper...



This salt-n-pepper shaker set was made from recycled walnut, reclaimed

from furniture waste, by a team of designers calling itself Design Aesthetic, based in Brooklyn, New York (USA). While both the shakers use cork for stoppers, the salt shaker was finished with low-VOC milk paint. Diane Ruengsorm, Melissa Chang, Nick Foley and Andrew Garrison believe in employing environment-friendly and certified wood, and all their products are recyclable and bio-degradable. More at: www.domestic-aesthetic.com

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Rover C Edge CNC Edgebanding center

www.biessemanufacturing.com



Blum's practical idea for narrow cabinets



The latest innovation in kitchen fittings by Blum for narrow cabinets delivers stability and quality of motion and enables end-users to make the most of every inch of storage space.

Narrow cabinets with a width of 200 mm are frequently used in kitchens: they normally serve as fillers at the side of cookers, or between a kitchenette and wall. Most conventional solutions on the market

use runner systems that are attached to only one side of the cabinet.

Blum has now developed a special solution for narrow cabinets that offers enhanced stability and greater load bearing capacity. Diagonally fitted runners produce far greater side stability than runners mounted to one side and can withstand loads of 20 kg per base unit.

Additional plus – you only need one set of runners per base unit. All components stem from Blum's existing product range, ensuring that the overall look of the kitchen is harmonious. The idea can be implemented with the Tandembox systems as well as with the Tandem and Movento runner systems for wooden drawers and pull-outs.

Advantages

- Using Blum standard fittings for most or even all applications (also for narrow cabinets) facilitates inventory management for furniture manufacturers
- The same drilling patterns and enhanced adjustment ease make manufacturing more efficient and assembly easier
- Customers are pleased with the harmonious look of the interior of their furniture and enjoy Blum's tried and tested quality of motion
- Narrow cabinets also excel in terms of little opening force, feather-light glide and soft-close Blumotion.

Ceiling-mounted cooker hoods

With Häfele's exquisite range of aesthetically pleasing cooker hoods from Falmec, Italy, you can give your customers the experience of perfect air ventilation amidst designer luxury within the kitchen.

Falmec hoods are made of AISI 304 steel, the only one that is truly stainless, thanks to the nickel that is part of its alloy. Besides the efficiency of its motors, special attention is given to noise reduction and 24-hour operational capability.

The stainless steel filters (with 5 aluminium layers for a higher level of efficiency over time) can be washed in

the dishwasher.

The latest addition to the series of cooker hoods by Falmec is the sleek and smart ceiling mounted hood, Nuvola. It fits snugly into the ceiling over your cooking hob, and works noiselessly with an efficient suction capacity of 1,000 cubic metres per hour.

The Nuvola cooker hood comes with a remote control device, and with integrated neon lighting. The tempered extra light painted glass panel is durable and adds an element of distinguished design to the cooker hood.





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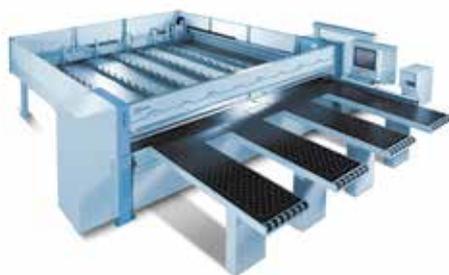
www.dieffenbacher.com

Holzma offers HPP series beam saws

The two series from Holzma are ideal for entry-level companies and those upgrading equipment. Plenty of power and functionality at a low cost see to that. However, larger companies that often work with small batches can also benefit from its strong features.

Even the extremely compact HPP 230 presents convincing efficiency and performance. It combines power, reliability and functionality in the smallest of spaces, an innovation which will help you complete your customers' orders swiftly and efficiently.

Even in its standard version, the HPP 230 offers impressive state-of-the-art technologies. A lot of a machine for a little money. Optional extras allow it to



be exploited to its full potential as and when the need arises. That pays off!

Advantages

- Compact price, compact size, genuine Holzma technology and quality
- Speed gives a competitive edge; shorter cutting cycles free up manpower
- Numerous optional extras provide even greater efficiency
- The only one with 3D graphics
- One-man operation
- Options can be retrofitted
- Ready for storage link-up

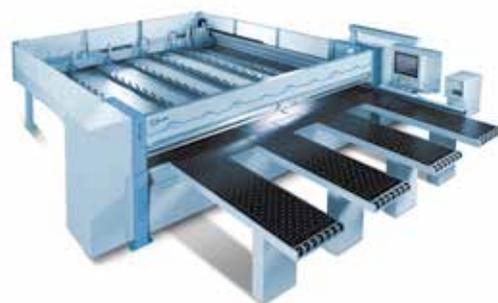
The HPP 250 goes one step further: it offers higher performance, with additional flexibility and more optional extras. It is the champion among small horizontal beam saws. The successful model has significant shorter cutting cycles and more

configuration options.

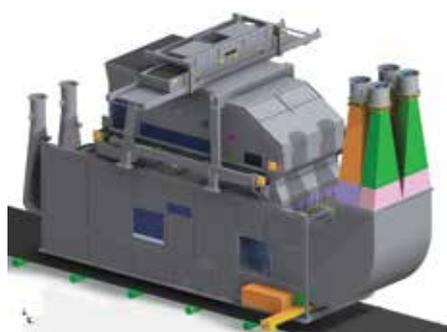
The range now includes a HPP 250 profiLine model, which is particularly suitable for complex storage link-ups. It also offers the possibility to incorporate the new feed-stacking table with integrated in-feed in combination with the new panel labeling system.

Advantages

- New design, transparent protective enclosure
- Manual trim stops & pressure regulation
- Energy chain now lying on the support
- More speed & enhanced range of optional extras
- HPP 250 now available as profiLine version
- For complex storage link-ups.



EcoFormer SL for particleboard plants



Siempelkamp is on the verge of unveiling another product innovation for particleboard production: the EcoFormer SL, which provides an even more uniform forming of the surface layer during production. The result: reduced material consumption and improved area weight tolerance.

The reduced pressure loss in the EcoFormer SL further allows the use of smaller blowers with lower energy

consumption. Material and energy savings add up, according to the plant size, to approximately €500,000 annually.

The German machine and plant engineering company will present the breakthrough at the International Woodworking Fair in Atlanta (US) in August this year.

Based on the success and experiences with the Ecoresinator for fibers, which has been sold 18 times since 2011, Siempelkamp recently developed an innovative resin blending system for particleboard production. The Ecoresinator for particles promises resin savings of up to 10% due to its special nozzle technology.

With its innovative mat pre-heating system, Conti Booster, Siempelkamp provides another product upgrade. Plant operators achieve, depending on

production conditions, roughly 20% higher outputs during the production of particleboard, MDF and OSB.

The intermediate belt in the in-feed area of the press is replaced with a steam-permeable screen belt. The steam distributors, which are mounted above and below the screen belt, inject up to 400 kg/h of saturated steam with a temperature ranging between 100°C and 130°C into each side of the mat.

Siempelkamp has also developed a new high-end press model for surface finishing. Due to the increased pressure of up to 700 N/cm², the KT700 opens up the prospect to manufacture high-quality and new products in the area of lamination. The special characteristics of the KT 700 are its multi-piston design and the new cylinder design.



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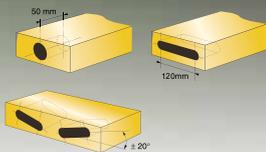


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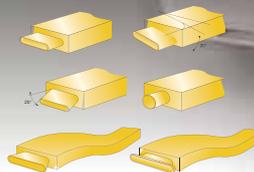
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Tece warns against cost-cutting on primer

Without primer, no matter which type of edge bander is used or which type of adhesive hot melt is used, the edge banding will not stick to the edges of a board. The primer is an invisible material on the back side of the edge banding; yet, it is an indispensable ingredient of it.

Primer is the single-most important material in ensuring the adhesion of edge banding to the panel edge as the extruded PVC has no proper bonding effect by itself.

The very primer that can be seen on the back of the edge banding can cost between 3 Euros and 10 Euros per kg. The edge banding manufacturer decides which one to use according to their experience and quality perception.

The amount of primer that can be applied can vary from between 15 gm per square metre to as high as 35 gm per square metre. In other words, the cost of 1 square metre of primer can be as high as 0.35 Euro or as low as



0.045 Euro.

Tece applies 30 gm of primer per square metre with the highest quality of primer. It only works with the world's leading German producer of this product: Jowat.

What if the edges of the very furniture that you sell start peeling off easily, or after a month of using it? Who can you blame? From Tece's experience no one will take responsibility.

The primer producer will blame the application method. The machine

producer would blame the glue, and so on. Cost on primer material should be considered as a good investment and as an insurance policy.

Conduct your own test and make sure that when the edge banding is peeled off, there are adequate particles from the chipboard on the surface of the edge banding. If you do not see chipboard particles in the edge banding, stay away from that material.

In the long run, as is said always, good quality will prevail!

Wood-Mizer releases multi-head resaw

Wood-Mizer's comprehensive range of single and multi-head horizontal resaw units are tailored towards providing for customised resaw solutions that suit individual requirements.

The company's Orange resaw range is split between the HR110, HR115 and HR120 models and answers the needs of the entry level through to professional saw miller that requires resaw capacity to streamline production further and reduce operating costs.

The introduction of the new HR700 furthers Wood-Mizer's industrial saw milling range with a larger capacity, modular, multi-head resaw. Its modularity makes it easy to expand from one to a maximum of six heads.

In its maximum configuration, the HR700 converts large cants into six boards and one slab in one pass. Cant capacity for the HR700 is 400-mm (width) by 400-mm (height). The shortest length that can be processed is 1 metre.

Each cutting head is equipped with a 15-kW electric motor, or optionally with an 18.5-kW motor. The resaw can be installed as a standalone unit, but has been designed to integrate into Wood-Mizer's current smart log processing (SLP) log processing lines. The HR700 uses the same size blade



The new HR700 horizontal resaw offers modularity and larger capacity for timber processors. Its cant capacity is 400 mm wide and 400 mm high.



as all other machines in the SLP lines, standardising ordering for customers to one blade size.

The basic HR700 module includes two heads as standard. To extend the resaw, all that is needed is to add another two-head module and install a longer conveyor belt.

The modular design makes transportation easier and less costly, as well as giving businesses the option to scale up their resaw capability as their business grows. For returning unfinished cants back through the resaw, roller tables are available for a manual cant return system.

A separate control stand holds all controls for the resaw. Standard, head height is positioned with a manual screw. Optional set works with electric up/down are available, which increases speed and precision when adjusting the heads to produce



Heavy, powered rollers stabilise and feed the cants through the heads during sawing. The twin-track steel belt conveyor provides a solid and durable surface that fully supports the entire cant width.

different sized timber.

Centralised blade tensioning for each two-head base makes the blade change process more efficient.

The twin-track steel belt conveyor provides a solid and durable surface that fully supports the entire cant width. Belt speed is variable up to 20 metres per minute. Heavy, powered rollers stabilise and feed the cants through the heads during sawing. This makes it easier to process short cants or material with internal

tension.

A pneumatic sensor automatically raises the rollers to accommodate incoming cants. The roller speed is synchronised with the conveyor belt speed, providing more precise cutting, especially for thin boards.

To support expanding the product range into larger machinery, Wood-Mizer completed construction of an additional production hall in early 2014.

“We want to be a provider of saw milling equipment to the timber industry at all levels,” says president and CEO, Mr. Richard Vivers. “The expansion of our European headquarters gives us a solid base to move up to the next stage in the saw milling industry globally.” To learn more, visit www.woodmizerasia.com.

– Etienne Nagel



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Inert Coating Technology advantages:

- Reduced coating consumption (-50% gr/m²)
- Reduced environmental impact (-75% CO²)
- Increased coating film resistance
- Reduced running costs (energy saving -65% kW and space reduction -60% m²)
- Lacquer applied in a perfectly smooth coat
- Panel defect filling
- Increased application tolerance



PiperWare: software for measuring systems in panel production

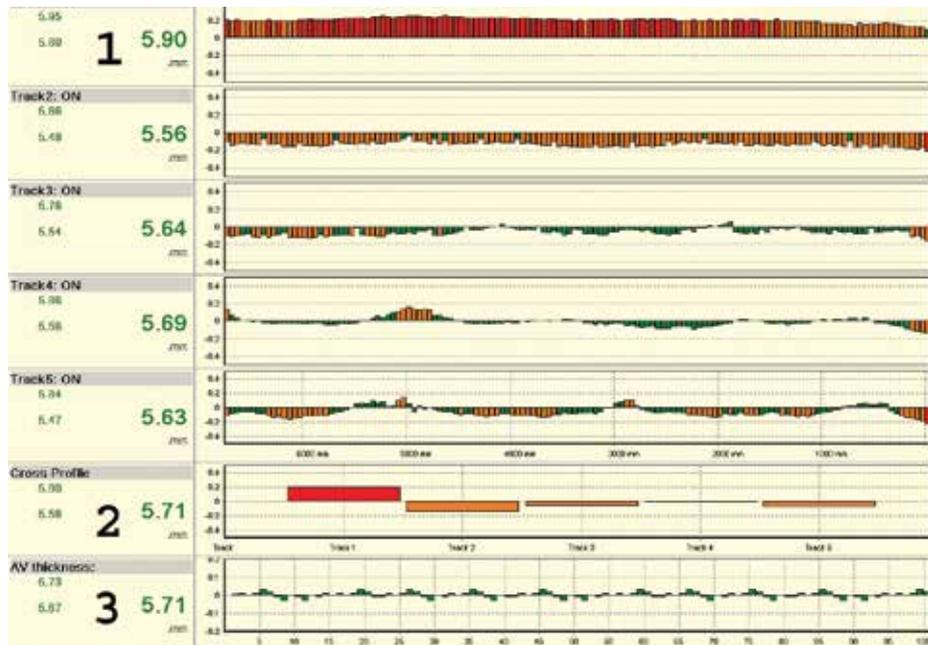
Alongside a wood panel production line, numerous measuring systems are built: moisture-measuring gauges in the drying and forming area, weight-per-unit-area gauge before the hot press, thickness measurement and blow detection system after the hot press and board scale before cooling. Press operators are faced with too much data along with numerous graphs appearing on the monitors. Each measuring system has its visualization on a monitor in the central control room. Actually, much of that data is shown in multiples. This has changed and improved with PiperWare.

Each measurement system involved reverts to the same visualization software. The operation thus becomes standard. A single view now will show the current status of the process. Diagnostics and status information can be retrieved, if required.

PiperWare reduces all information to the basics. Only the points of interest are shown and, superfluous data (ballast) is cleared out. Warnings and important event messages are superimposed automatically.

The new-era weight measuring technology for thin panel board production is available from Electronic Wood Systems (EWS), based in Hamelin, Germany. The technology comes in the form of two new models which have been added to EWS's existing standard area weight measuring system, Mass-Scan X.

The first model 'LowEnergy' is for thin board production and the second model 'DualEnergy' caters for thin as well as thick board



Display of thickness tracks and thickness profile across the production line.

production. 'Centerpiece' is a super-sensitive detector which can receive and quickly evaluate extreme low x-ray energy radiation. Thickness Gauge 'Thick-Scan' is for MDF, HDF, particleboard, OSB, OSL, LVL, plywood and others.

Continuous thickness measurement avoids waste of raw material. Production of panels which exceed plus tolerance results in increase of production cost, as well as consumption of additional (unneeded) glue and other material, while also extending the press time.

The EWS thickness measuring systems help to optimize the process and to reduce costs while, at the same time, assuring quality standard. If the gauges are located in the sanding line, the service life of the sanding belts is shortened.

Panel thickness tolerances have been measured during production by hand-held devices. Today, however, such measurement is carried out continuously online. In the majority of plants, quality control is not the first priority for new investment for online thickness measurement. The current trend is to achieve the enormous potential savings in wood raw material, resin and energy consumption.

Thick-Scan prevents such losses. Another feature is that the system is designed to be installed on a continuous production basis – providing online calibration without a gap between panels (patented).



'Reference-Track' for online calibration (in red).

The measuring heads are mounted opposite to each other and indicate panel thickness continuously during production. It also helps avoid additional maintenance work compared to a movable C-frame solution. A higher measuring accuracy is ensured by taking environmental temperature into account.

It visualizes cross-length profiles, trends per track (minimum, maximum and mean value) and can be installed either after the hot press or before/ between the sander. EWS claims an accuracy of +/- 0.02 mm, and gives a guarantee of 20 years on mechanical wear of linear sensors. It can work at top production speed of 3.5 metres per second.

Electronic Wood Systems (EWS) is an innovative company in the field of measurement, quality and production management systems for the panel board industry. It offers a complete range of quality supervising systems at competitive prices featuring high precision, robustness, system integration and low maintenance. (www.electronic-wood-systems.de)



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BR 2600 membrane press: 11 sold and still counting!



 Brother's BR 2600 membrane press.

The Indian furniture industry has always been maintaining a constant pace in growth over the last few years. The percentage of users of panel-based furniture in the Indian market is continuing to expand rapidly. This is due to the exponential growth in domestic housing and commercial sectors.

Dimensional accuracy and durability of the furniture is a must. However, the real part of the business which makes the end user to go in for good furniture lies in the finish of the product. This is a very challenging job to a manufacturer these days.

The immense problems faced by manufacturers in controlling the attrition rate in labor are far bigger than controlling finances in the business these days. As such, it is always advisable to go in for dependable, high quality and long life bearing machinery to support the business at all times.

Brother from Korea is one such company that manufactures high quality membrane presses that are sold worldwide and have gained acceptance by many a reputed manufacturer of membrane-based products in many countries today.

Brother has sold more than 900 units so far with many more pending orders. Brother entered India in 2011 and has already sold 11 units of its popular model, called the BR 2600. Some of the reputed brands manufacturing kitchen shutters in India – such as Shapez from Andhra Pradesh and Ellenza in Karnataka – still make their quality shutters on Brother membrane presses.

Other users of Brother membrane presses in India manufacture doors and various other profiles used for the paneling, skirting and various other applications still use the Model BR 2600 effectively till date.

Roblandvebim Machinery in Bangalore have been authorized by Brother to market their high quality membrane presses in the Indian market due to Robland's past and present reputation in offering high quality panel processing machinery to the Indian clientele.

A membrane press is far more superior than a vacuum press in terms of quality achieved, durability and acceptability of the finished product. While a vacuum press delivers the end product with only suction power, the membrane press not only pulls down

the foil with a powerful combination of calculated heat and suction through a perfected heating systems and a high capacity vacuum pump but also presses upon the laminate from the top surface with an intermediate silicon rubber sheet to impart the maximum finish on to the surface of the panel.

This ensures the perfect finish and imparts a very high quality in finish and life of the end product. The BR 2600 has unique features like a reciprocating twin table in a single direction which reduces space, unique heating pattern system, very low maintenance and an unbelievable price which is hard for other European brands to match.

Brother machines offer a 5-year warranty on the table lifting system, a life-time warranty on the table projection system and a special 6-month money-back guarantee.

To know more about the Brother BR 2600 membrane press, email: info@roblandvebim.com.





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Biesse's Jade 200 series: top quality edging

The Jade 200 series comprises of the Jade 240 and Jade 225, automatic single-sided edge banders capable of applying a perfect finish to edge banding material such as PVC, veneer coils, and single strips of HPL and solid wood.

The hallmarks of these machines are perfectly edged panels time and again. The new Jade 200 series offers various features that are similar to those of high end edge banding machines such as

- Heavy-duty top-pressure beam with a staggered dual roller system on precision bearings to guarantee proper panel hold-down along with the industrial track and chain with a round and flat guide system, and an industrial quick change glue system with direct gear drive system.
- HSD Rotax high-precision, high-frequency motors to help provide a high quality finish to the panel edges and 7" touch screen PLC control panel.

Pre-milling unit

- This unit is used to make perfect the edge of the panel prior to applying the edging. Scoring marks, chipping on the edges can be removed with this unit. It ensures edging with an almost invisible glue line. Pre-milling unit is equipped with two, timed intervention motors of 1.8 kW @12,000 rpm.
- Auto-set device for pre-milling improves quality by ensuring chipping-free panel edges and uniform wear on the cutter.



Gluing unit

- Glue pot capacity of 2.5 kg
- Automatic loading for edge in

rolls, manual loading for edge in strips

- Pressure rollers: 1 motorized roller + 2 idle rollers
- Adjustable pressure rollers, through digital indicator
- Gluing application through spreading roller and copier to avoid a direct contact with the panel and to achieve right glue thickness.



The glue pot is completely coated with non-sticky material (Teflon) for easy cleaning. Automatic temperature lowering of the glue pot when the machine is temporarily left unused.

End trimming

- Two motors of 0.8 kW rating with trimming blades tilting 0-15 degrees
- Automatic adjustment according to the panel thickness
- Automatic titling from 1st to 2nd run
- Flex system is standard on Jade 240, ensures overhang of front and rear edge of panel for processing on the corner rounding unit.



Fine milling

- Automatic adjustment according

to panel thickness

- Quick change motors with horizontal and vertical copiers: 2+2 self-cleaning disks
- Easy adjustment of multi-profile tool (straight and radius profile).



Corner rounding

- Two high frequency motors of 0.65 kW, with 12000 rpm, managing both trimming and corner rounding
- Maximum panel thickness of 60 mm
- Rounding of synthetic edges from 1-3 mm thick glued on straight panels.



Edge scraping

- It finishes PVC/ABS/PMMA/PP edge material
- Automatic adjustment according to panel thickness
- Two horizontal disk copiers + 2 vertical disk copiers.
- The glue scraper removes glue overflow between edge and panel
- Buffing unit comprises of brushes with 2 motors for cleaning and finishing the panels.



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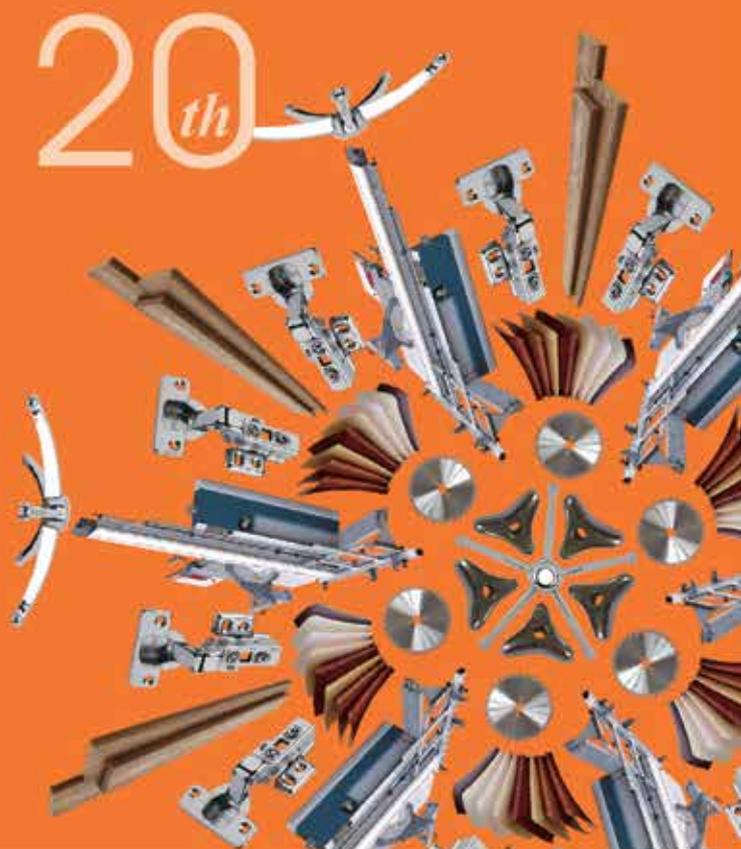


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- ▶ Expanding the field of exhibits to decoration, engineering applications
- ▶ Expanding the field of visitors to the hotel project, decoration
- ▶ Upholstery furniture is moved in SWEECC
- ▶ Eight domestic and overseas associations has participated

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Umaboy shines at IndiaWood 2014

Engineered and innovative machines continue to be the key to success for Shree Umiya F Tech Machines 'Umaboy'. At IndiaWood-2014, a number of visitors and customers appreciated the range of products displayed and gave their positive reviews. Some also ordered machines and discussed complete solutions for their upcoming expansion plans.

Among the new launches at IndiaWood (February 2014) were:

Automatic Edge Bander (UEB-3600)

Description	Parameter
Electrical Level	380-220/50 Hz
Nominal Current	18 Amp
Edge Material Thickness	0.4-3 mm
Board Thickness	10-50 mm
Speed	15m/ MNH
Total Electrical Power	11 kW
Total Air Pressure	6 Bar
Total Air Usage	160 IT
Trimming	2x0.75 kW/18,000 RPM
Glue Boiler Engine	0.18 kW / 900 RPM
Pallet Motors	1.1 kW /900 RPM
Machine Length	3600 mm
Machine Width	800 mm
Machine Height	1500 mm



Membrane Press (UMP 1016)

Description	Parameter
Overall Size	6475(L) x2080(W) x2025(H) mm
Working Size	1300x 2600 mm
Max. Work Height	50 mm
Working Pressure	Positive < 0.7 mpa, Negative >-0.95 mpa
General Power	25 KW
Top Temperature	150° C

The 'Positive-Negative' membrane press manufactured by Umaboy was another attraction at IndiaWood-2014.

Umaboy proudly announced a tie-up for the Indian market with Moxsabir from Turkey which introduced an innovative machine model, the U 2600 (through feed edge bander with corner rounding), at a very competitive price.



WOODNEWS

WoodNews thanks the various companies that have submitted information. For any editorial submissions, please contact Mr. Dhananjay Sardeshpande, Chief Editor, at dhananjay@pdatrademedia.com. The information published in this, *Events, Products and Processes, Notes and News* sections is as per the details furnished by the respective manufacturer/distributor. It does not reflect the views of WoodNews or of the management of PDA Trade Media.



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WOODNEWS

Salvador bags award at Xylexpo

“For us it was really a huge achievement to win the first prize at the Xia-Xylexpo innovation awards, decreed by the journalists in the field, in the communication category,” said Mr. Christian Salvador after receiving the plaque from Mr. Ambrogio Delachi, President of Eumabois, and Mr. Lorenzo Primultini, president Acimall, the association of Italian woodworking machinery manufacturers.

“A moment of great intensity and strong emotion, a demonstration that what we believe in allows us to be counted among the protagonists, even if we are and want to continue to remain a small, strong, proactive company in the industry,” added the head of Salvador Srl, the Italian saw specialist.

Xylexpo 2014 was a further confirmation of the validity of the range of Salvador’s optimizing saws and cross-cut saws. In Milan, the exhibited products included a Superpush 200 optimizing pushing



saw whose standard version provides maximum flexibility and whose ‘Window’ version becomes a solution addressed to the world of doors and windows.

Next to it was the “latest born” of the Supercut 500 family, the ‘Super Fast’ version, which is the perfect answer for glue panels production. Salvador

also exhibited the updated Classic 50, an entry-level manual cross-cut saw, and the Superangle 600, at Xylexpo.

Salvador Srl was established 35 years ago in San Vendemiano, in the province of Treviso, in the heart of one of the most important districts in terms of furniture production in Europe.

Henkel to simplify product brand portfolio

Henkel Adhesive Technologies India Pvt. Ltd., the market leader in adhesives, sealants and surface treatments, has unveiled a new branding strategy to organise its growing product portfolio under five technology cluster brands.

As a result of numerous acquisitions, Henkel’s portfolio of brands has grown over the decades and has enabled the company to become the global market leader in adhesives, sealants and surface treatment solutions.

But a survey recently conducted by

Henkel clearly emphasized that its large and complex portfolio of brands and product names was difficult to understand by the markets and customers.

Loctite is Henkel’s brand for engineered, high performance adhesive, sealant and coating solutions. Bonderite products represent its surface technology solutions that create competitive advantage in the customers’ manufacturing processes.

Technomelt is Henkel’s brand for hot melt adhesives, designed for

best results in application and production processes. Teroson is the brand for bonding, sealing, coating and reinforcing in automotive body and vehicle repair and maintenance applications. Aquence is now the brand for innovative, sustainable water-based adhesive solutions.

The rebranding exercise will only modify the product naming; there will be no changes to the product composition, chemical formulation or the article codes of Henkel’s products. (www.henkel.com)

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VDMA board is reconstituted

At this year's VDMA trade association woodworking machinery elections within the members' general meeting, Mr. Frank Diez, Managing Director of Ledermann GmbH & Co., and Mr. Ralf Spindler, Managing Director (Sales & Marketing) at Robert Bürkle GmbH, were newly elected to the board.

The VDMA board represents the German woodworking industry's product segments and now comprises of: Messrs Wolfgang Pöschl (Chairman) of Michael Weinig AG, Dieter Siempelkamp (Honorary Chairman) of G. Siempelkamp GmbH & Co., Wilfried Altendorf of Wilhelm Altendorf GmbH & Co., Stefan Brand of Vollmer Werke GmbH, Dieter Brucklacher of Leitz GmbH & Co., Frank Diez of Ledermann GmbH &



 *Members of the reconstituted board of the German woodworking industry's trade association after the recent elections.*

Co., Markus Flik of Homag Group AG, Matthias Krauss of Mafell AG, Klaus-Jürgen Lange of Anthon GmbH, Stefan Möhringer of Simon Möhringer GmbH,

Peter Schaeidt of Baljer & Zembrod GmbH, Rüdiger Schliekmann of IMA Klessmann GmbH, and Ralf Spindler of Robert Bürkle GmbH.

Intermob, WPM fairs poised for growth

The biggest fairs of the industry in Eurasia – Wood Processing Machinery (WPM) and Intermob fairs – are preparing to open the doors from September 27 to October 1, 2014, at Tuyap Fair Convention and Congress Center, in Buyukcekmece, Istanbul, the capital of Turkey.

The fairs already have achieved 70% of the sales target and will be realized by the active participation of domestic and international companies. Representatives of leading companies and governments in Iran have also been contacted. Sales and marketing activities were conducted during Mebel Fair (Russia), Holz-Handwerk Fair (Germany), Modef Fair (Turkey) and Xylexpo (Italy).

Last year Intermob attracted 880 companies and their representatives from 30 countries. It was visited by 59,697 visitors from 86 countries. The exhibition is spread over 14 halls on 1,20,000 square metres.

In 2014, there will be also new companies operating in furniture

upholstery products and technologies. The professional exhibitors and visitors will take the opportunity of observing the last technologies on wood processing machinery, furniture accessories and forestry products.

Turkey is located equidistant from Caucasia, the Balkans, West Asia, North Africa, Western and Central

Asia, which together account for 1.5 billion of the Earth's population.

The two fairs create an important trading platform for small and middle-sized companies requiring to build their own brands. For more information visit www.intermobistanbul.com and www.woodmachineryistanbul.com.



 *A view of Intermob, held in Istanbul, in 2013.*

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Post-poll prospects look good

The election victory of the Narendra Modi-led Bharatiya Janata Party has been welcomed by the business community as the new central government is expected to be “more pro-business”. Of special interest is whether the new administration will eliminate the controversial 2012 legislation that allowed for retroactive corporate taxes.

India’s business community is very happy, say analysts, as the country will now have a stable government with a business-friendly leader, which could herald unprecedented industrial growth. Housing sector business houses have reacted positively and

anticipate determined action to tackle inflation.

Almost all Indian plywood mills have been compelled to increase prices. While demand in the main cities remains subdued, housing and infrastructure developments in second and third tier towns are keeping plywood makers busy. The new government has plans to further expand these new towns to ease the pressure in the housing market in the main cities.

The impact of the log export ban in Myanmar will eventually have a pronounced effect on the plantation teak market in India. Over time the

industry will be more dependent on domestic teak resources and will slowly have to introduce other tropical timbers as substitutes for Myanmar teak.

Export demand for teak products processed in India is steady, and millers still have reasonable stocks. However, teak prices will continue to climb as log stocks fall.

During May and June the usual series of auctions of domestic logs were postponed on account of the general elections. At the time of going to the press the auction programme for June was yet to be announced. – ITTO

‘Wood Excellence Prize’ up for grabs



Architect Matteo Thun
Pic: Francesca Lotti.

The World Architecture Festival (WAF) has announced that this year’s WAF awards programme will feature a ‘Wood Excellence Prize’ for the first time. WAF is the largest annual festival and awards programme for the global architecture community. It is set to take place at Marina Bay Sands in Singapore between October 1-3, 2014. Sponsored by the American Hardwood Export Council (AHEC), any type of project can be entered. The only criterion is that wood is an integral part of the project.

Entry into the prize is free and, if shortlisted, the designers or architects responsible will be invited to present their project to the prize judges live at the festival. The winner will be announced at the WAF awards ceremony on October 3, 2014.

Architects of every shortlisted project are invited to attend the festival to

give a live presentation to a panel of judges, asserting their case for why their project should win. The winners of each category are put forward to compete for the coveted World Building of the Year award, presided over by the festival’s ‘super-jury’.

Architect, designer and a champion of wood in architecture, Mr. Matteo Thun, will chair the jury for the prize. This year’s super-jury members are Messrs Richard Rogers, Rocco Yim, Julie Eizenberg, Enric Ruiz Geli and Peter Rich.

For details visit www.americanhardwood.org.



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Associate Decor launches book on engineered wood & design

In its ongoing endeavour to impart the right information and handpicked decors to its customers, Associate Decor has teamed up with IFJ, a leading product and design magazine, to launch a book, *Engineered Wood Designs: Infinite Possibilities of Flatline Furniture*.

The book was unveiled by industry veterans, Mr. Ramu Ramakrishnan and Mr. Snehal Vasani, on 23rd May at the Lalit Ashok hotel in Bangalore. The book opens up a world of opportunities for the use of pre-laminated particleboards, in particular melamine-faced particleboard, their numerous uses and benefits.

Although pre-laminated particleboards and MDF contribute over 85% of the total engineered wood panels market globally, in India particleboards are yet to become the preferred choice for customers and



recommending authorities. This is due to the inconsistent and cheap product quality of boards manufactured by the unorganised sector.

Associate Décor has marked the advent of furniture-grade particleboards in the Indian market along with its

E1 Class, E0 Class and HMR-grade boards for kitchen segment. These are available in more than 100 designs with matching post-forming laminates. To order a copy, write to ewd.adl@associategroup.in.

ANNOUNCING DELHIWOOD 2015



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www.delhi-wood.com

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We at PDA Trade Fairs and Eumabois take pride in continuously enhancing exhibitor & visitor experience at our trade shows, and acting as catalysts in the growth of the woodworking industry in India.

Riding on the success of previous exhibitions, the 4th edition of DELHIWOOD will take off at the India Expo Centre & Mart, Greater Noida, from February 4- 7, 2015.

The international trade fair for Furniture Production Technology, Woodworking Machinery, Tools, Fittings, Accessories, Raw Materials & Products is expected to

attract around 450 exhibitors from more than 20 countries, and approximately 15,000 visitors from all over India and neighboring countries.

The Indian furniture market is estimated to grow at a compound annual growth rate of 25% through fiscal 2015-19, along with the (organized and unorganized) woodworking industry. The rising proportion of working age population, increasing per capita income, rise of the consumer class, rapid urbanization and growth of the real estate sector are some of the contributors to the

woodworking sector's growth.

This positive trend and market sentiment will reflect in participation at DELHIWOOD 2015, where exhibitors will showcase not only Woodworking Machinery, Furniture Accessories & Fittings, but also Systems & Tools for Woodworking.

DELHIWOOD 2015 is sure to be of great value for Furniture Manufacturers and other Woodworking Professionals to compare, benchmark & source machinery and materials.

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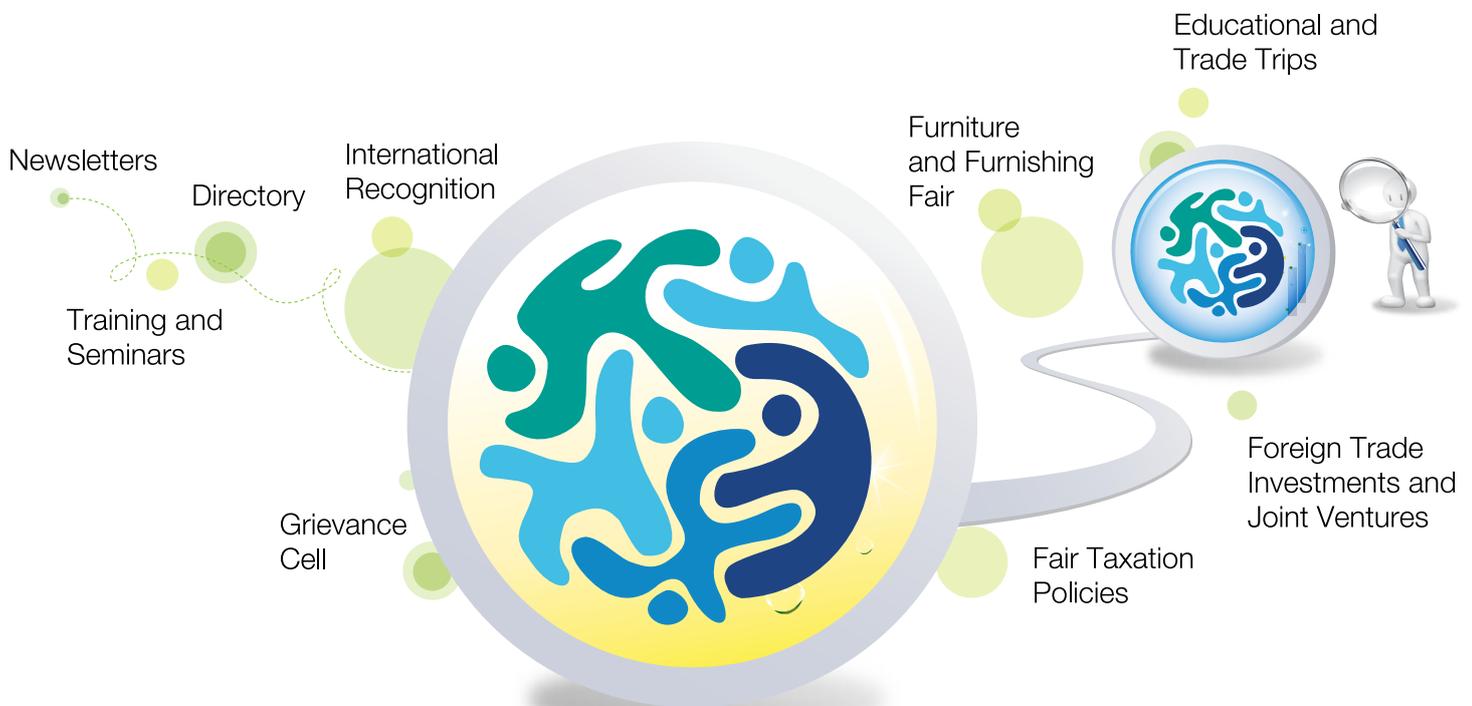


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Official Magazine

WOODNEWS

Robland Z3200 panel saw



The Robland Z3200 panel saw is a heavy duty machine which needs minimum maintenance to achieve great results. However, periodical and preventive maintenance of the machine ensures accuracy, ease of operation, reduces wear and tear of parts, increases durability and gives reliable performance.

Working with any machine requires constant attention and care. The machine can be used safely if the operator strictly follows the operating and safety instructions given in the manual.

Periodic maintenance has to be performed on a calendar basis. Preventive maintenance is performed while a machine is still in working order to keep it from breaking down. It includes lubricating, tightening and replacing worn parts.

Breakdown maintenance, on the

other hand, is performed on broken machines to restore them to working order. Planned maintenance is performed purposely and regularly in order to prevent a machine from deteriorating or breaking down.

Total productive maintenance happens with a manufacturing improvement method that increases production and reduces waste through continuous attention to the condition of machines and processes. It's main goal is to maximize equipment usefulness across its lifespan.

Ultimate results

- It is absolutely essential to read the manual before using the machine, so you know how the machine works and what its limitations are;
- Always make sure that all safety devices are fitted to the machine and that it is connected to a dust extraction system;

- Provide sufficient space and good lighting around the machine in the workshop;
- When changing tools or when conducting maintenance, the machine must be disconnected from its power supply;
- Knives and tools are not correctly sharpened, or in bad condition, diminish the quality of the work and increase the risk of accidents;
- Always wear suitable clothing and keep children away from the workshop;
- We recommend you wear ear protection when working with the machine.

Machine Maintenance

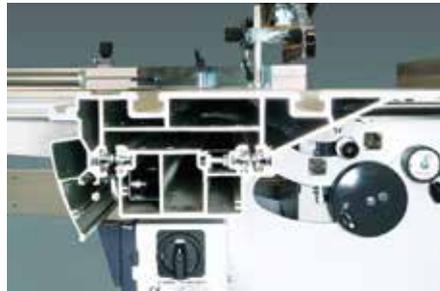
- Interior and exterior of machine must be cleaned regularly to avoid accumulation of dust and woodchips;



- Any deposition of resin on the sliding table and other surfaces has to be removed;
- All moving parts have to be kept clean and lubricated with thin oil, diesel or penetrating oil;
- All bearings in the machine are double-sealed and need no lubrication;
- Use of a dust extraction system will certainly extend the life of your machine;
- Life of motors can be extended by blowing out sawdust from the cooling fan and motor.

Sliding table

- It is recommended to clean the sliding table thrice a week, and to remove all sawdust and chips;
- From both sides of the sliding table blow out the dust between two sections and on the ball carrier;
- This can be done efficiently when upper part of the sliding table is



slid to the rear, and must then be repeated with the upper part at the front end;

- After all dust has been blown out, a thin oil with a Teflon base or plain diesel oil should be sprayed onto the steel V-liner strips on upper and lower parts of sliding table;
- Never use a thick oil or grease.

Trouble shooting

- Machine does not start when the start button is activated? The main fuse could have been switched off due to power shortage or motor

overload. The star-delta switch could be in the wrong position: put switch on “star”.

- Reduction of speed when working? Check and correct the belt tension, and sharpen any blunt tools. There could also be a motor overload due to incorrect feed rate: reduce the feed rate.
- Vibration of the saw blade or arbor? Replace or have the tool balanced. Also replace the worn-out or damaged belt.
- Thermal overload does not re-arm automatically after shut-off and cooling down period? Perhaps the overload is not set on automatic reset, or the overload is faulty.

If you cannot solve the problem yourself – or you do not find your problem in this list – please contact Robland technical service department. service@roblandvebim.com

EVENTS CALENDAR

International Woodworking Fair

Dates: 20-23 August, 2014

Venue: Georgia World Congress Center, Atlanta (USA)

IWF is where the material processing and design industries come together to solve problems and find solutions, share ideas with friends old and new, and reconnect with customers. You can source for products, ideas, and new ways to improve your company.

Details: www.iwfatlanta.com.

Intermob 2014

Dates: 27 September to 1 October

Venue: Tuyap, Istanbul, Turkey

The 17th international furniture side industry, accessories, forestry products and wood technology fair continues to be unique international trade platform of the forestry products and furniture industries in Eurasia. It also pursues the development of the industry and trade potential in the international market by the support of sector representatives, NGOs and media organizations.

Details: www.tuyap.tr.

India Furniture Expo

Dates: 22-25 August, 2014

Venue: Nehru Centre, Dr. Annie Besant Road, Worli, Mumbai (India).

The Association of Furniture Manufacturers and Traders (India) & Introduction Trade Shows Pvt. Ltd. present the second edition of the expo, which will showcase the latest designs & trends and eco-friendly products from all over India and overseas.



WHAT DO YOU THINK?

WOODNEWS

George Fernandez, Director, Systems Engineering Consultants, Chennai (Tamil Nadu):

Refer to *WoodNews* (May-June 2014) article on bamboo beams and cross-laminated beams by Abhinav Tewari and Yeo Heng Mau. In Parallel Strand Technology, long strands of Douglas Fir are used especially in the US in construction.

Glulam is also a highly engineered wood product, flexible, stronger and lighter than steel, fire resistant and ecologically sustainable. This information needs to be disseminated country wide by the North-East Centre for Technology.

Yogesh Patel, Partner, Patel & Company Plastic Division, Mumbai (Maharashtra):

I liked *WoodNews* (May-June 2014 issue) very much, especially the wood flooring article, 'Down to Earth'. I would like to read articles on ready furniture and similar products in forthcoming issues of *WoodNews*.

A.M. Mujibur Rahman, Mass Furniture, Chennai (Tamil Nadu):

Thanks to *WoodNews*, we have news about a variety of technologies to improve our business knowledge. We want more. Thanks to your team!

S.M.K. Jeelani, Director, Synor Industrial & Trading Co., Coimbatore (Tamil Nadu):

WoodNews has been a valuable source of information with product knowledge about new trends and concepts for people in the woodworking industry, especially for furniture manufacturers and dealers.

R. Sri Rengadurai, Civil Engineer, Sri Builders, Dindigul (Tamil Nadu):

These particulars from *WoodNews* are useful to me for furniture planning and my projects. I also give advice to my suppliers based on knowledge I glean from the magazine.

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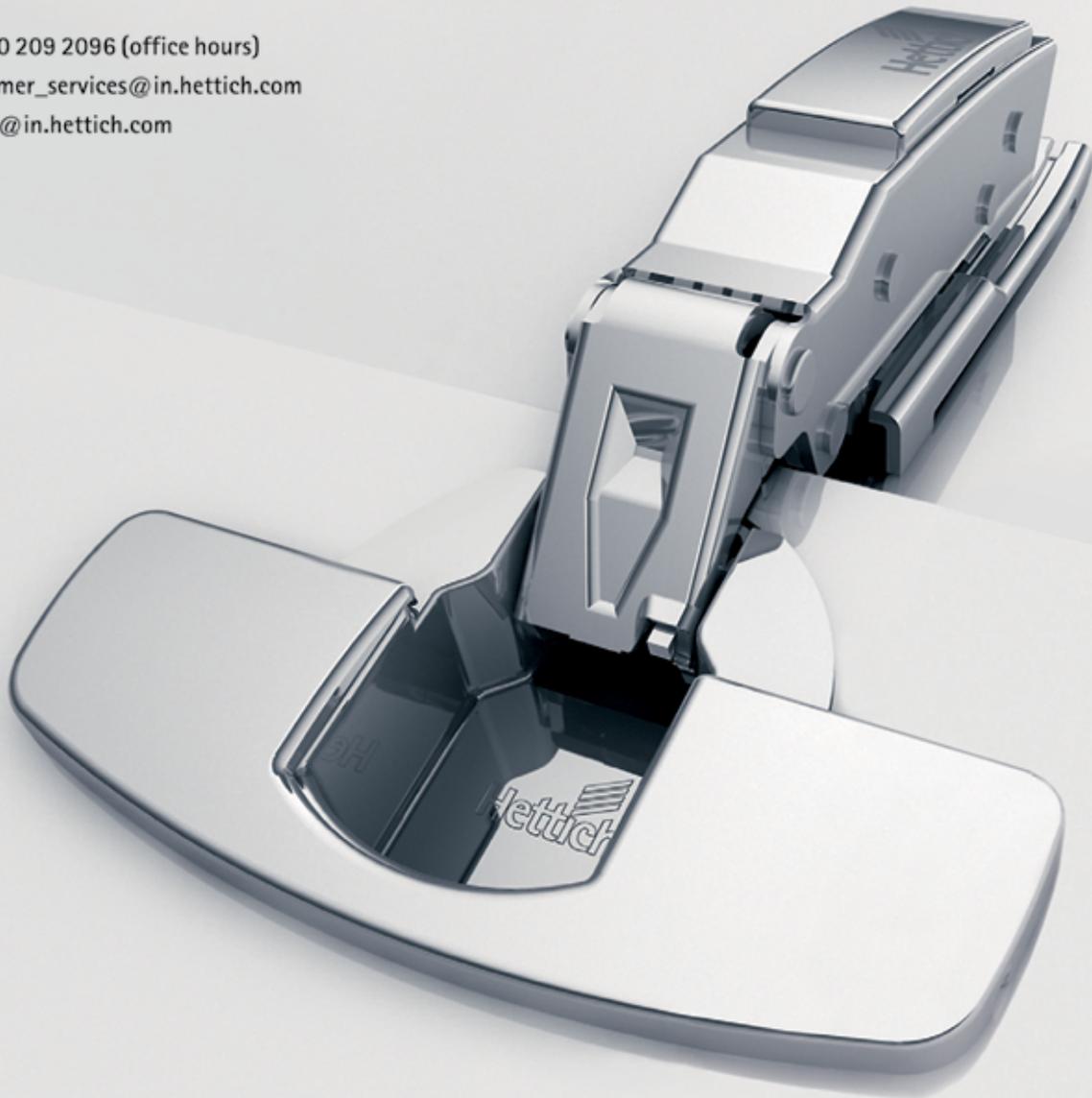
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